

FIG. 1

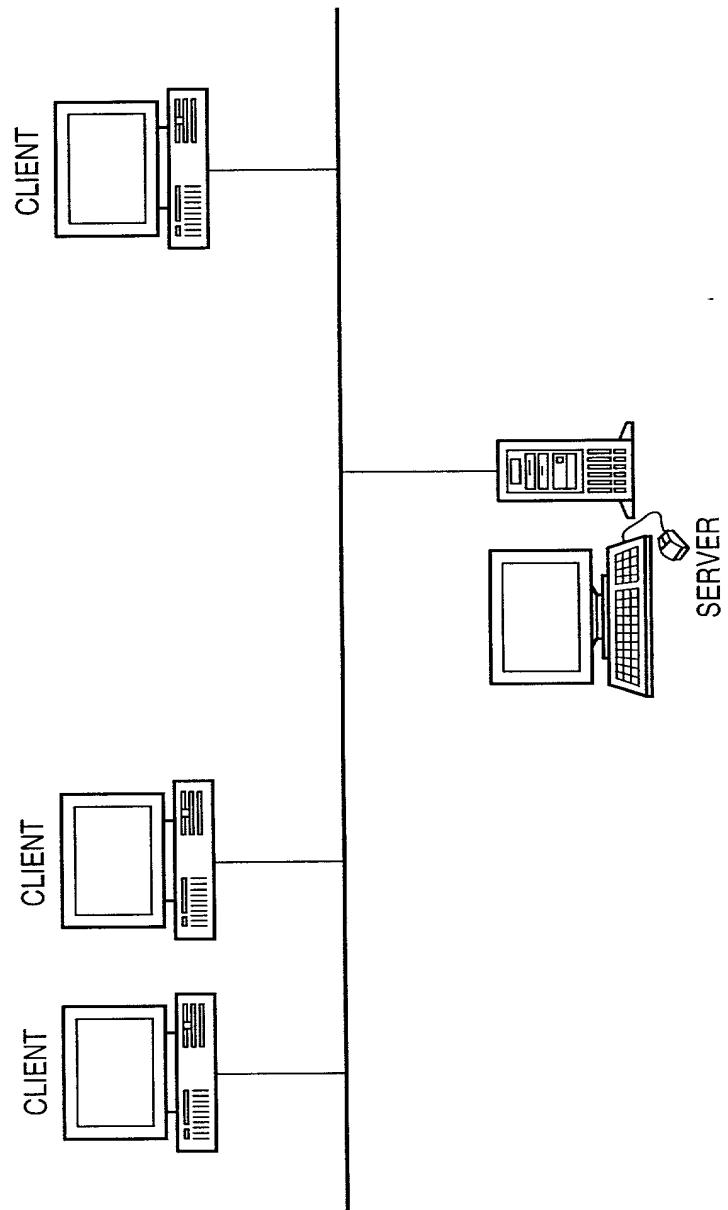


FIG. 2

REPRESENTATIVE MODEL A

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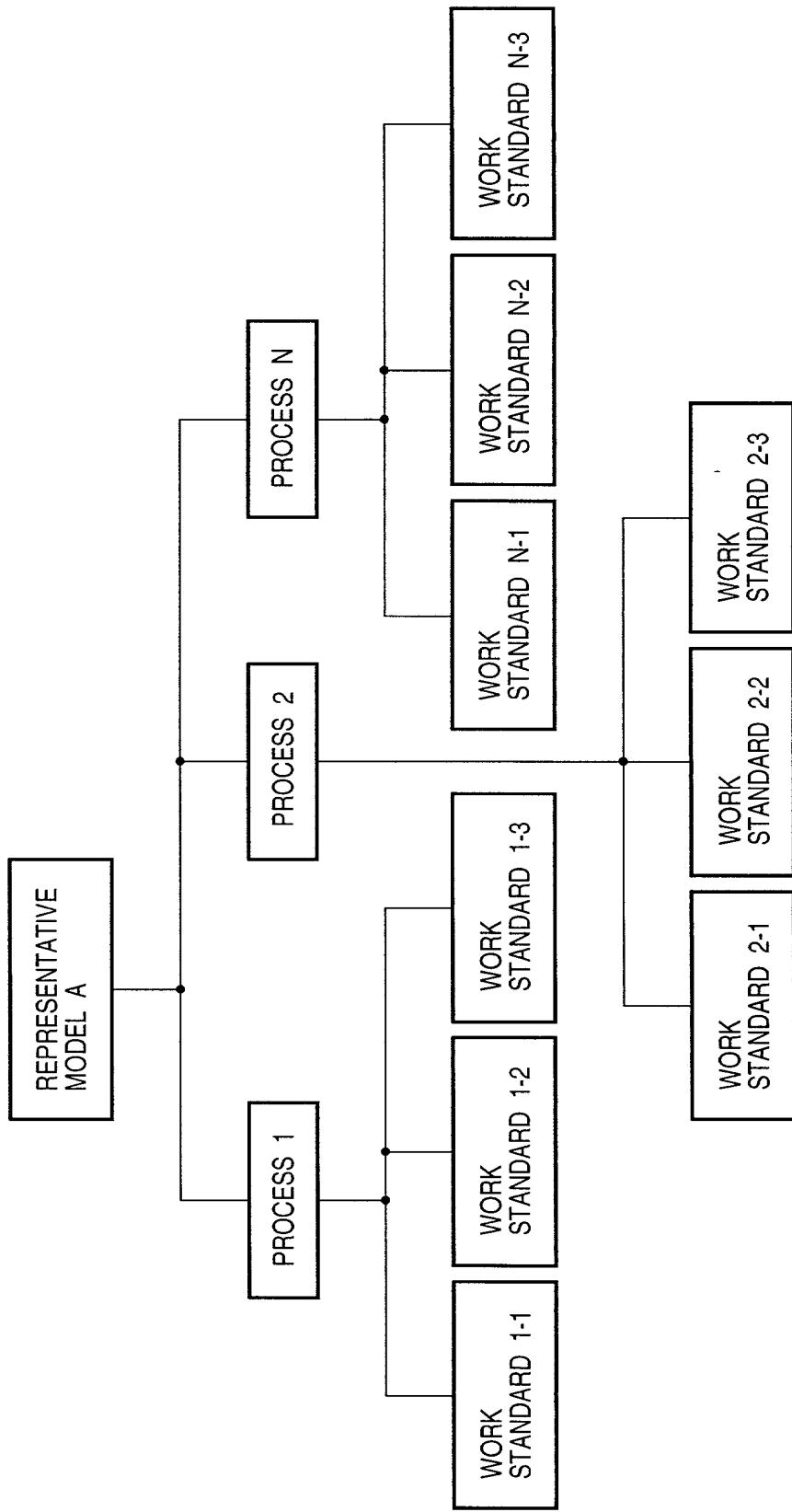


FIG. 3

302

WORK STANDARD 01 CREATION

APPLIED

300

301

PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY
303	304	305			

TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL

306

307

308

No.	WORK PROCEDURE	No.	NOTE / STANDARD ETC.
309	310		

313

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FIG. 4

STRUCTURE OF MASTER FILE

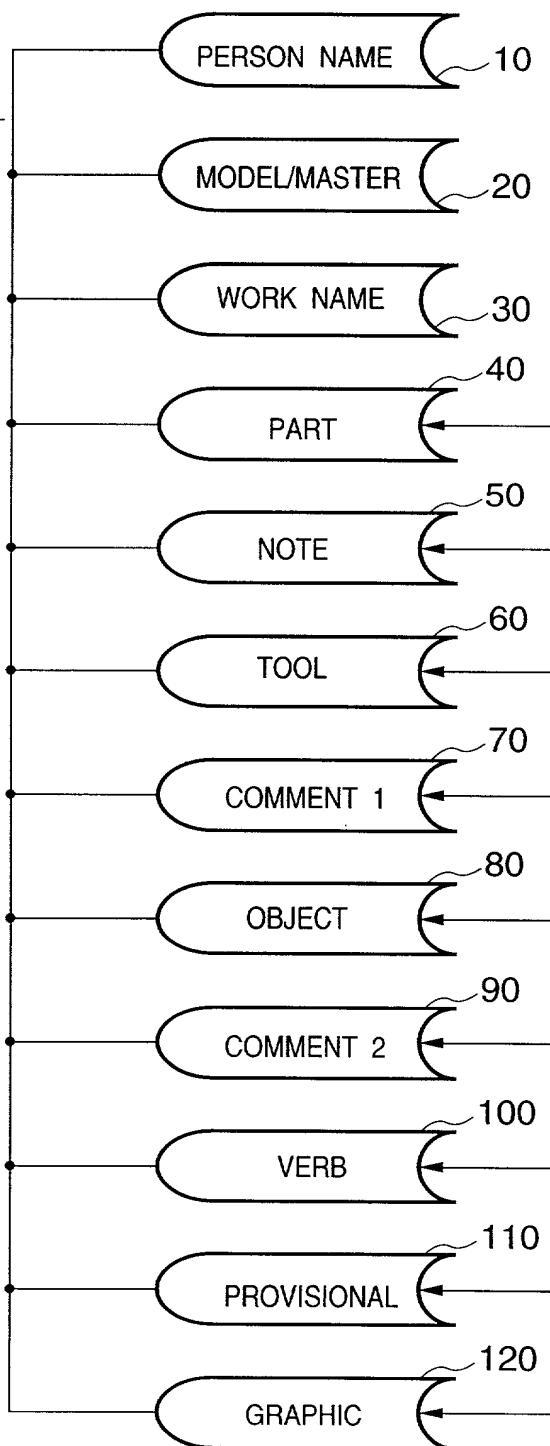


FIG. 5

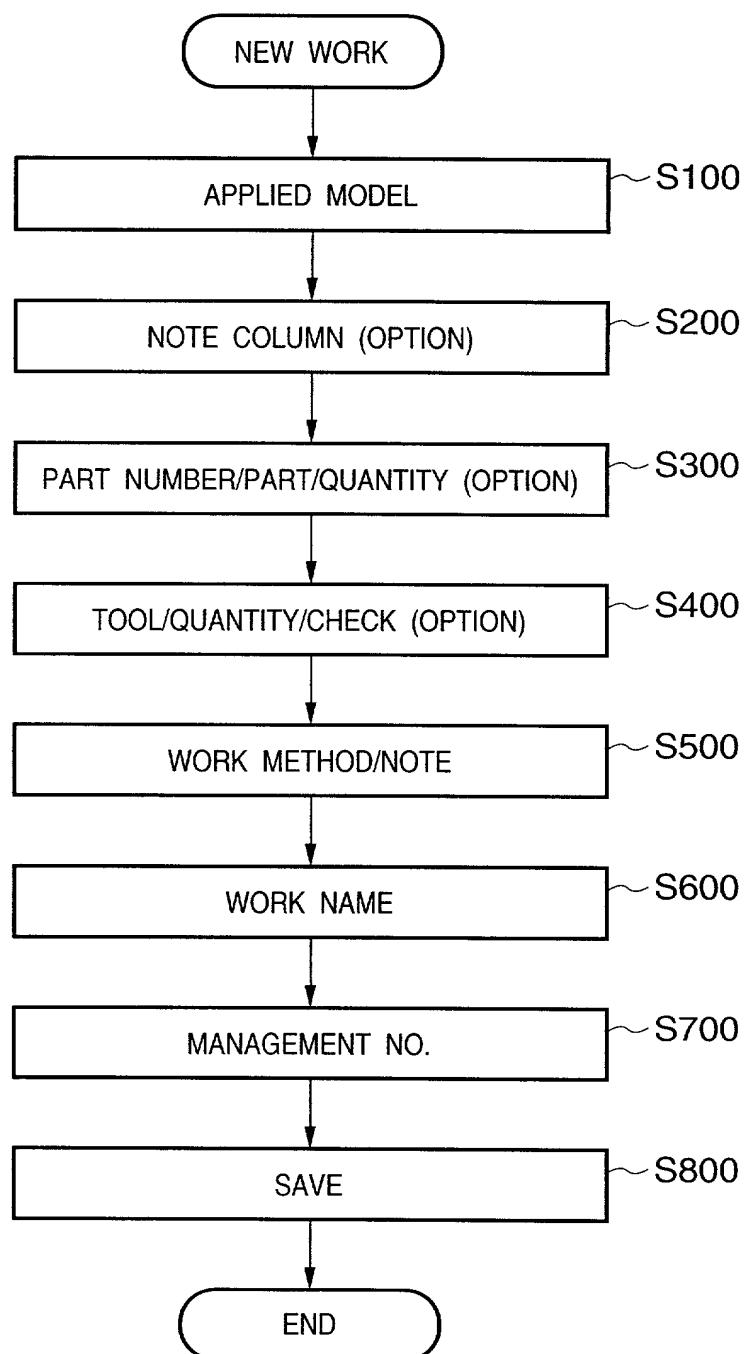


FIG. 6

SELECTION OF APPLIED MODEL	
LIST OF APPLIED MODELS	
BJC-4200 SYSTEM	
BJC-420J	
BJC-420J (BLACK)	
BJC-4300	
BJC-430J	
BJC-4200LX	
A250 II Q	
BJC-4200	
OK	CANCEL

FIG. 7

WORK STANDARD 01 CREATION	<input type="checkbox"/>	<input checked="" type="checkbox"/>
APPLIED	BJC-420J	BJC-420J(BLACK) BJC-430J
PART NUMBER	PART NAME	QUANTITY PART NUMBER PART NAME QUANTITY

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001		▲
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101		
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		▼

FIG. 9

- WORK NAME
- CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS
PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL
RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE
PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN
DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 10

• WORK NAME

現像(GENZOU) _____

• CANDIDATES

現像(GENZOU) レール戻しバネ掛け(HOOK DEVELOPING
RAIL RETURN SPRING)

現像(GENZOU) レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI) トナーなしチェック(CHECK NO TONER
IN DEVELOPER)

現像機(GENZOUKI) エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI) ロック(LOCK DEVELOPER)

FIG. 11

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WORK STANDARD SYSTEM	
WORK NAME :	1100
WORK METHOD :	
1101 ~	(COMMENT 1)
1102 ~	(OBJECT) ~を
1103 ~	(COMMENT 2)
1104 ~	(VERB) ~する
00	1105a
01	1105b
	1105
NOTE, STANDARD / REQUIRED QUALITY :	
1106 ~	
1107 ~	
	OK CANCEL
	1108

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FIG. 12

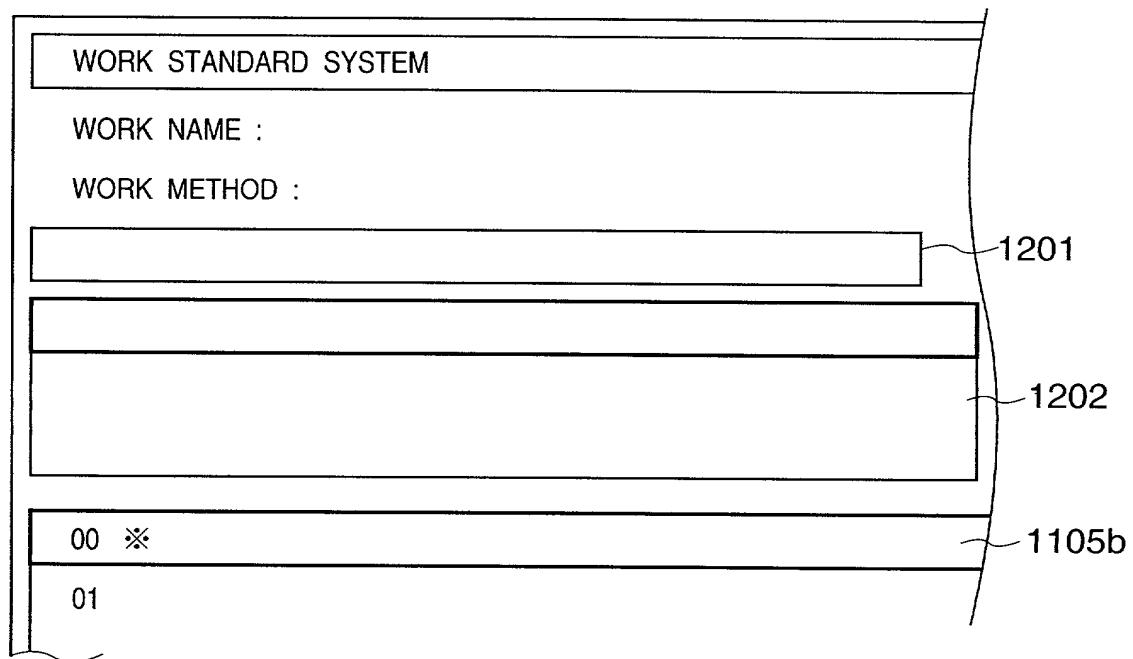


FIG. 13

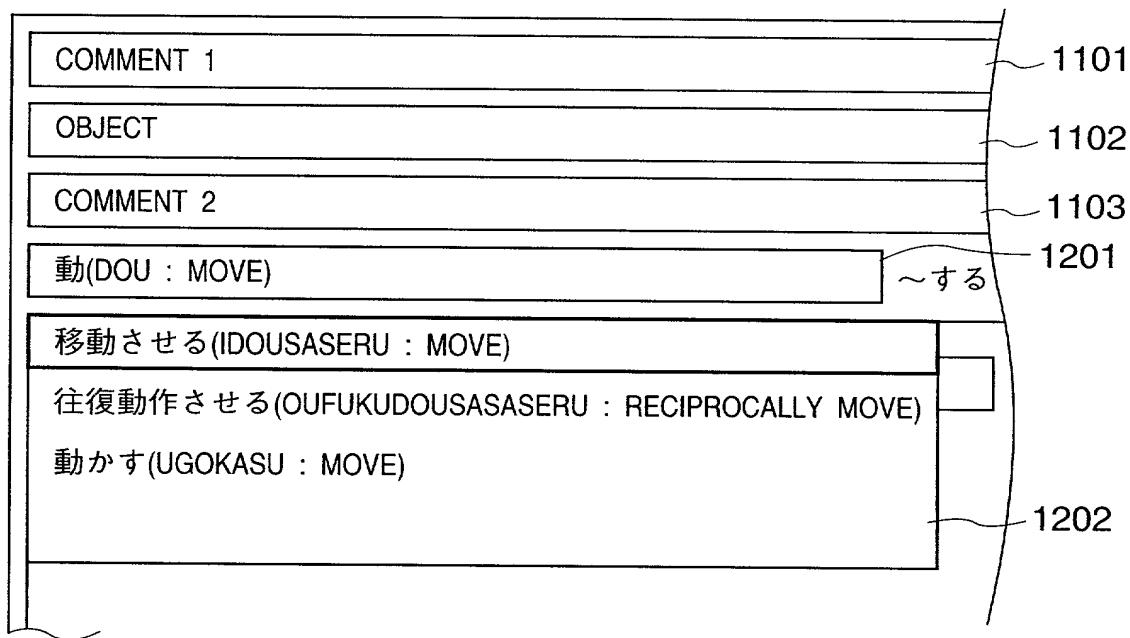
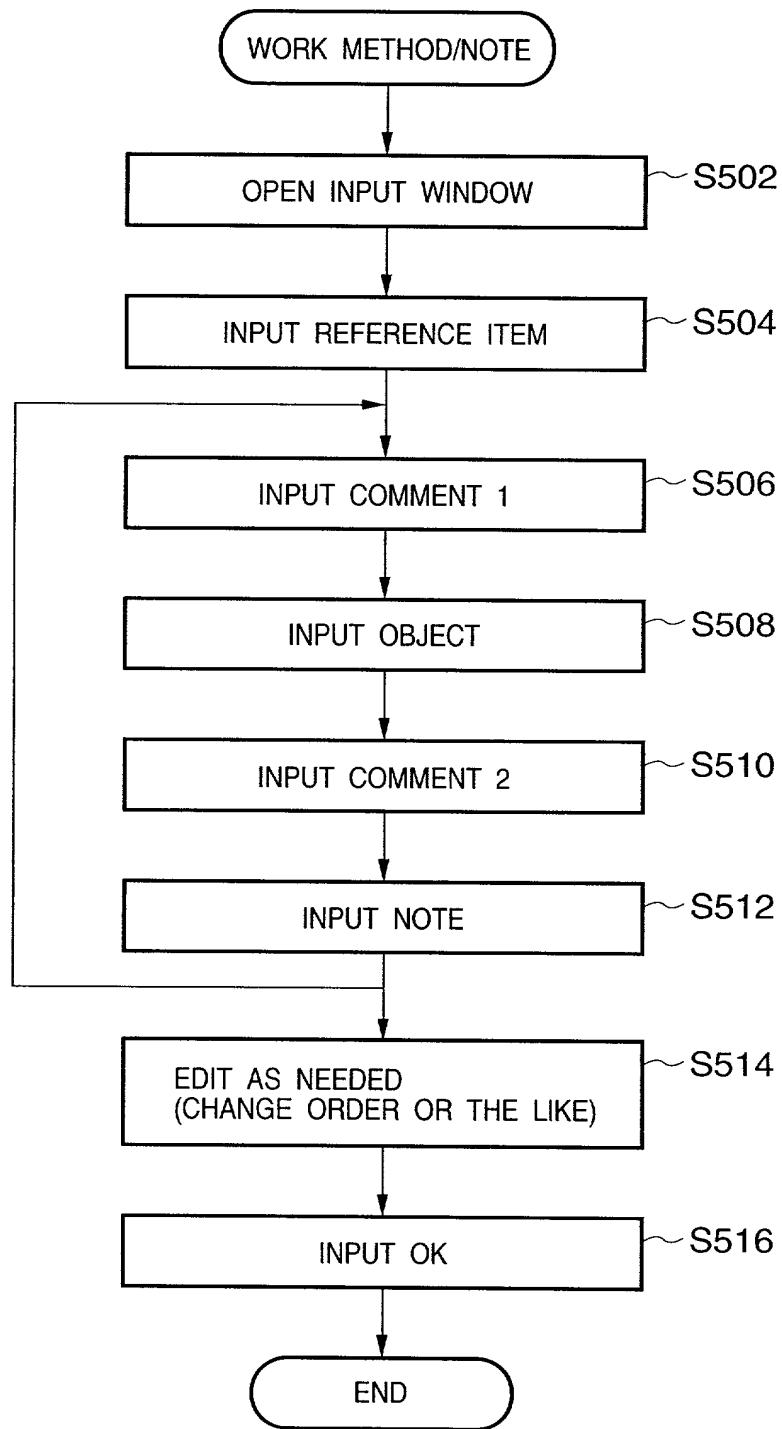


FIG. 14



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FIG. 15

00	※
01	DO zzzz SUCH THAT xxxx AT www POSITION BECOMES yyyy
02	WIND AV CORD
03	CONFIRM 100V SYSTEM
04	SET CRG HOLDER

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FIG. 16

NOTE, STANDARD / REQUIRED QUALITY

NOTE |

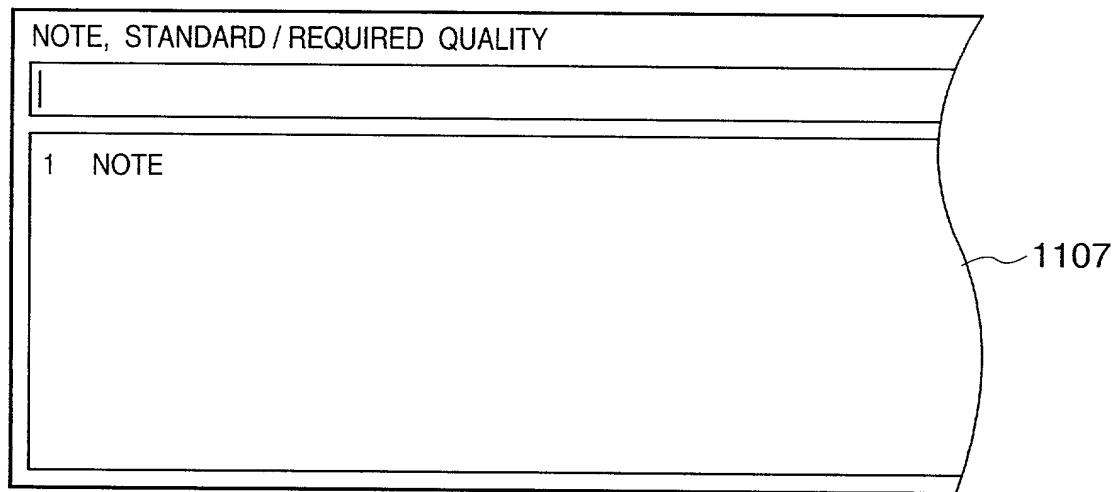
SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu
DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE
DON'T HOOK PAPER GUIDE u ON SHEET HOLDER
BEWARE OF IMITATIONS
BEWARE OF IMITATIONS(Color Style Write)

1601

1602

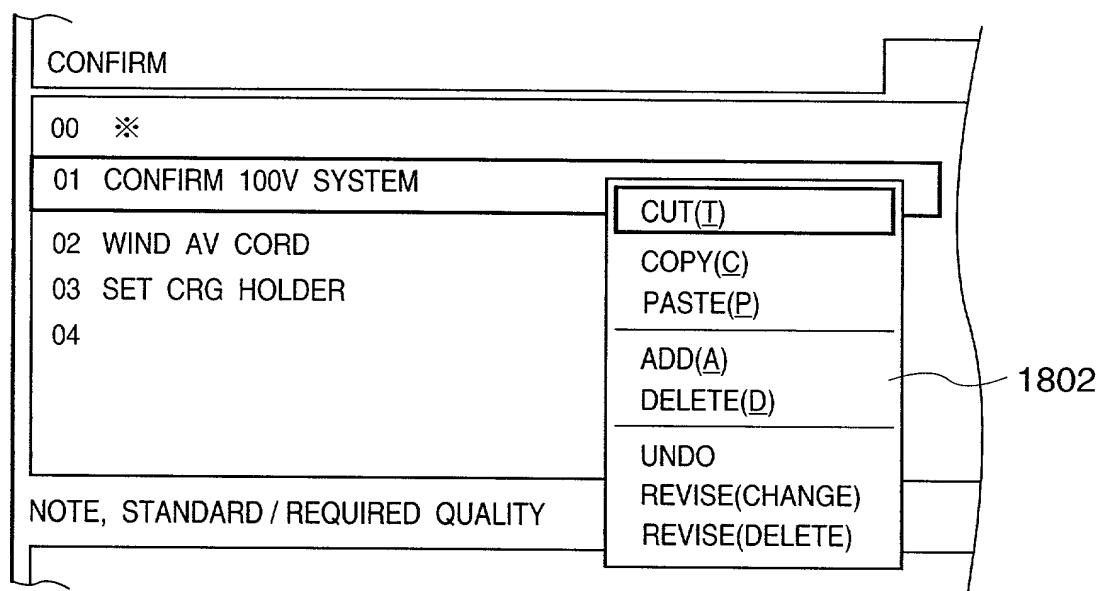
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FIG. 17



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FIG. 18



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FIG. 19

CONFIRM	～する
00 *	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

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FIG. 20

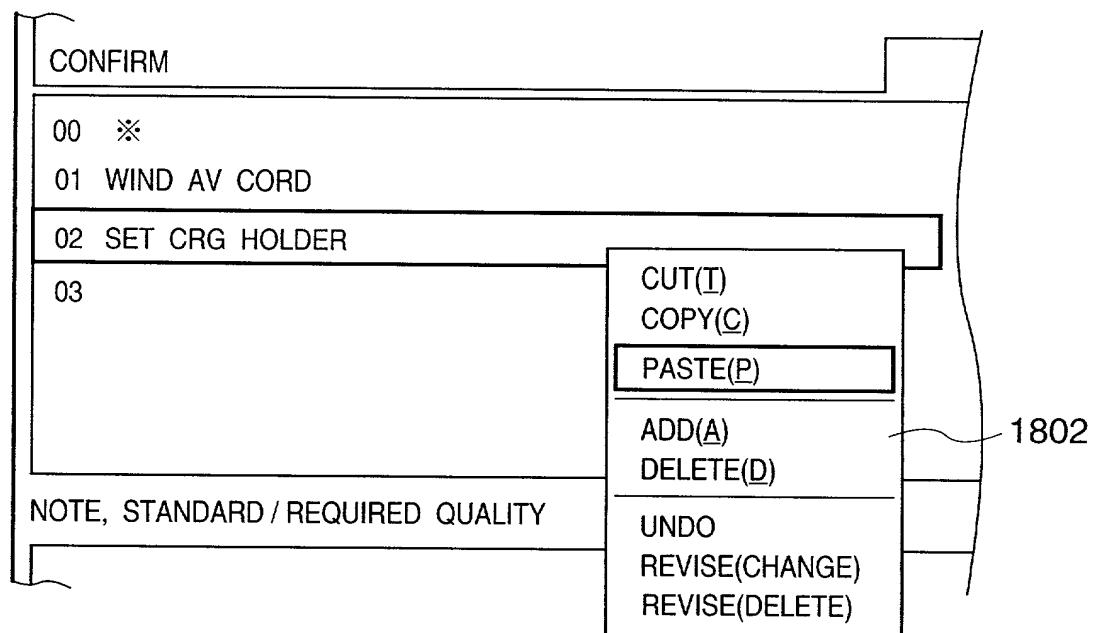
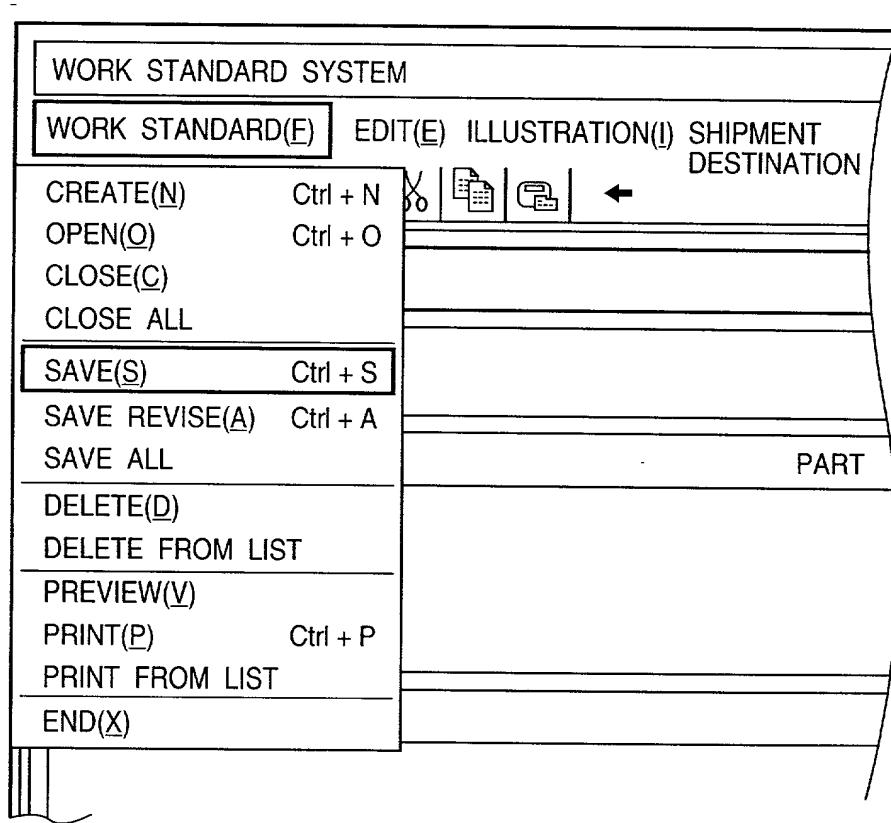


FIG. 21



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FIG. 22

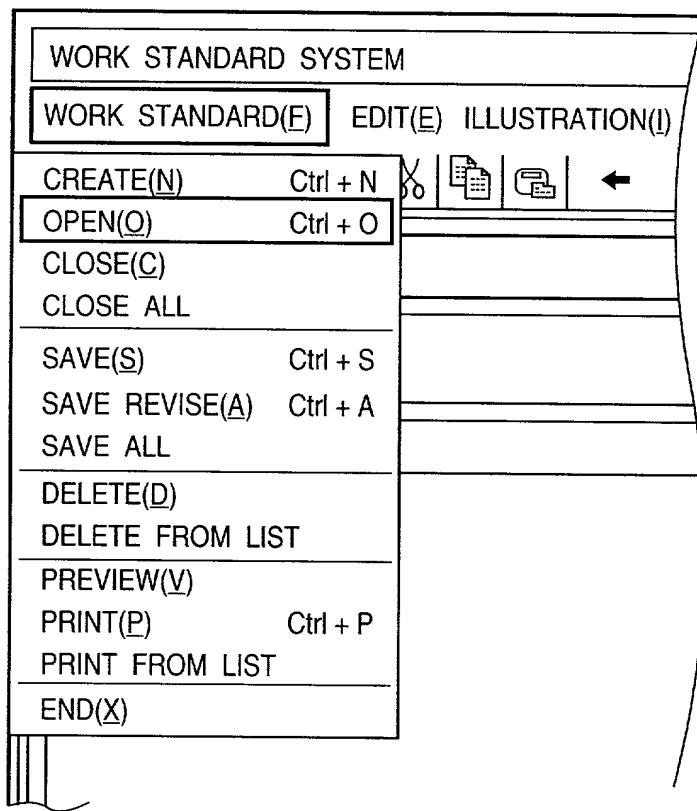


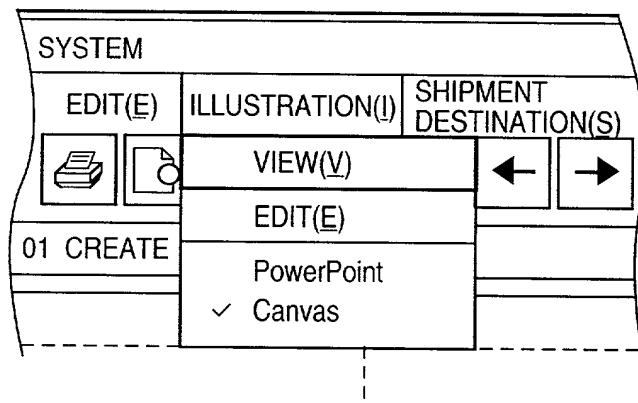
FIG. 23

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WORK STANDARD SYSTEM			
<input checked="" type="radio"/> LATEST REVISION NUMBER <input type="radio"/> ALL			
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO - 04 - 01(4) - E	01	ASFu取付	1997/09/13
SO - 01 - 01(3) - E	01	ベース・トレード取付	1997/09/01
SO - 01 - 03 - E	01	ベース・トレード取付	1997/09/01
SO - 01 - 04 - E	01	ベース・トレード取付	1997/09/01
◀ ▶			
SO - 06 - 01 - E	01	線処理	1997/09/01
SO - 06 - 02 - E	01	線処理	1997/09/01
SO - 06 - 03 - E	01	線処理	1997/09/01
SO - 07 - 01(2) - E	01	レールグリス塗布	1997/09/01
SO - 08 - 01 - E	01	レール取付	1997/09/01
◀ ▶			
		OK	CANCEL

2301

FIG. 24



25/97

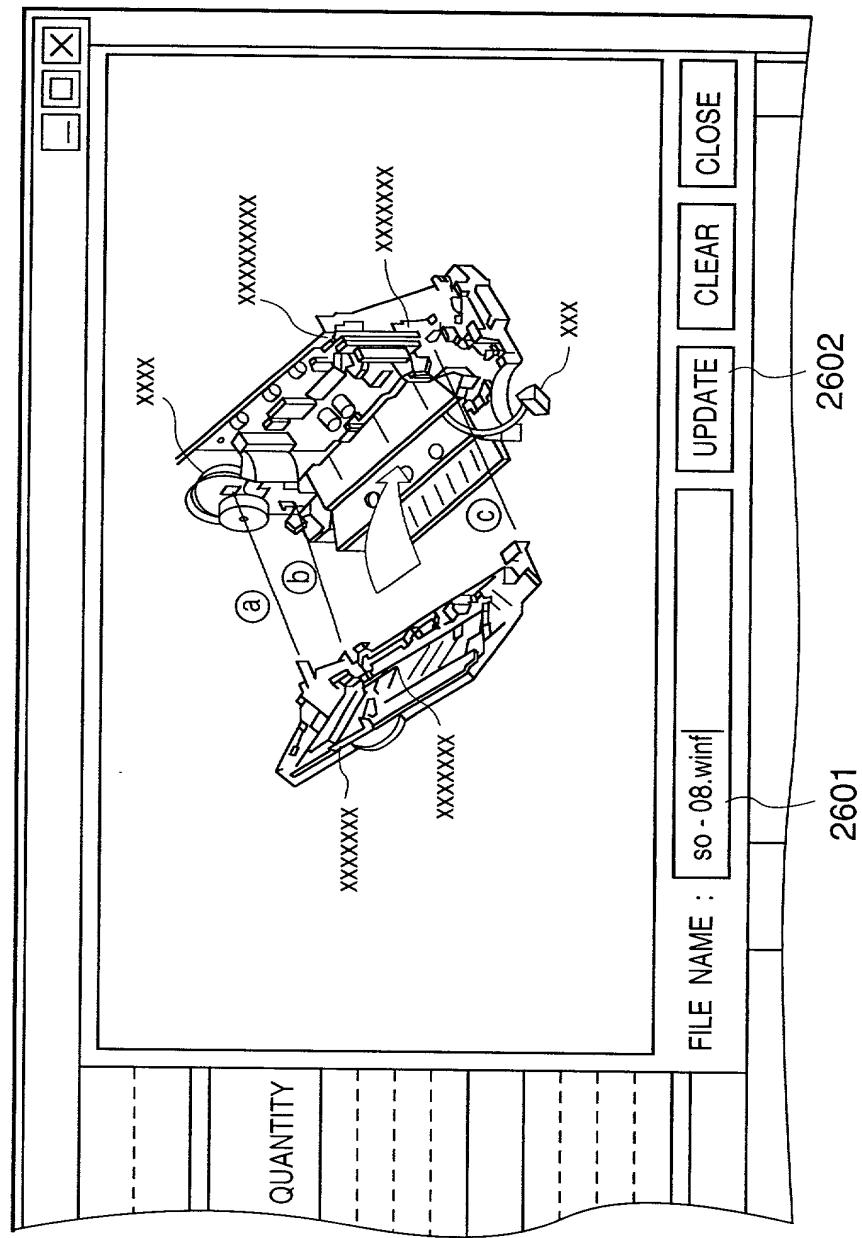
2500

FIG. 25

302

WORK STANDARD 01 CREATION			
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
APPLIED			
PART NUMBER	PART NAME		
303			
TOOL / TREATMENT DEVICE			
<input style="width: 100px; height: 100px; border: 1px solid black; margin-bottom: 10px;" type="text"/> <div style="display: flex; justify-content: space-around; border: 1px solid black; padding: 2px; margin-bottom: 10px;"> FILE NAME : UPDATE CLEAR CLOSE </div> <div style="display: flex; justify-content: space-around; border: 1px solid black; padding: 2px; margin-bottom: 10px;"> 2501 2502 2503 2504 </div>			
No.	WORK PROCEDURE		
REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE
01	CREATED	1997/09/25	APPROVE
			WORK NAME
			MANAGEMENT NO.

FIG. 26



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FIG. 27

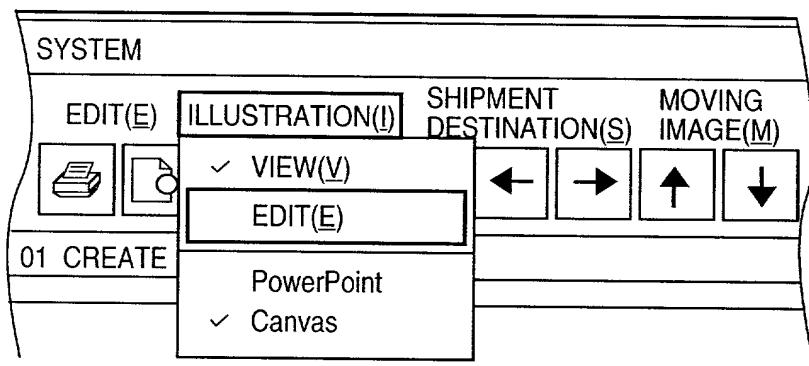


FIG. 28

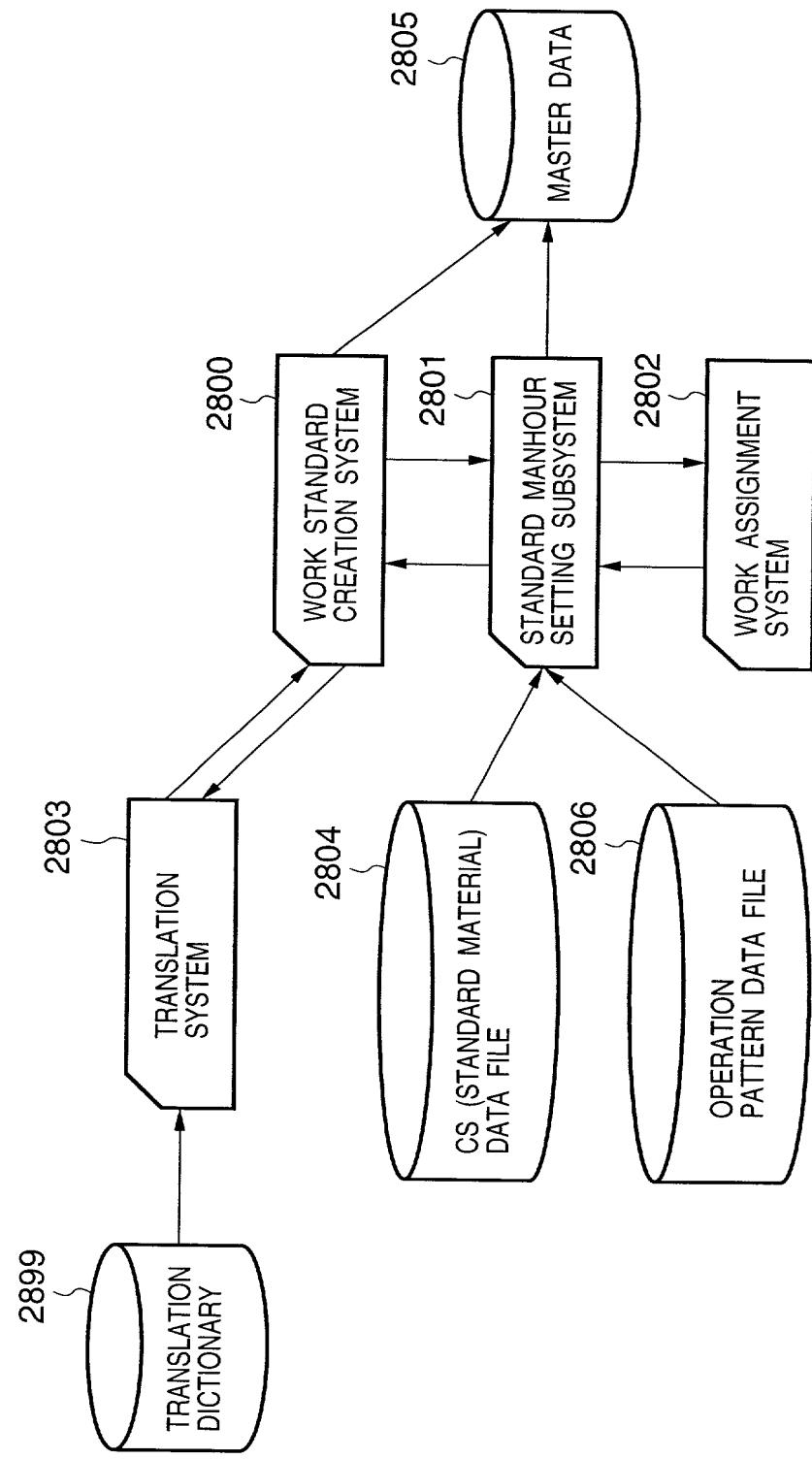


FIG. 29

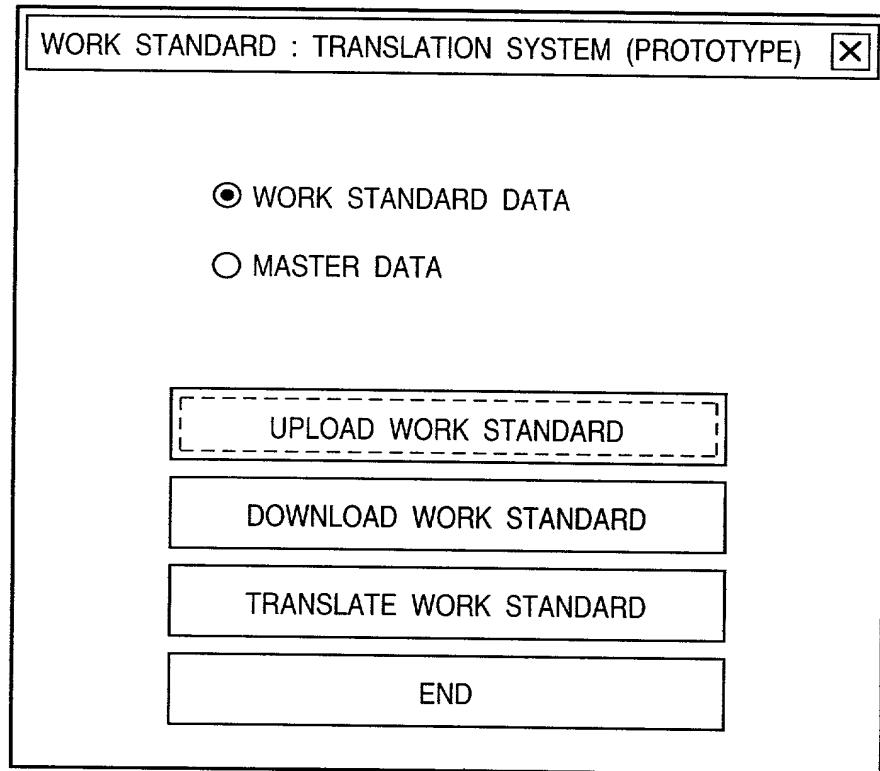


FIG. 30

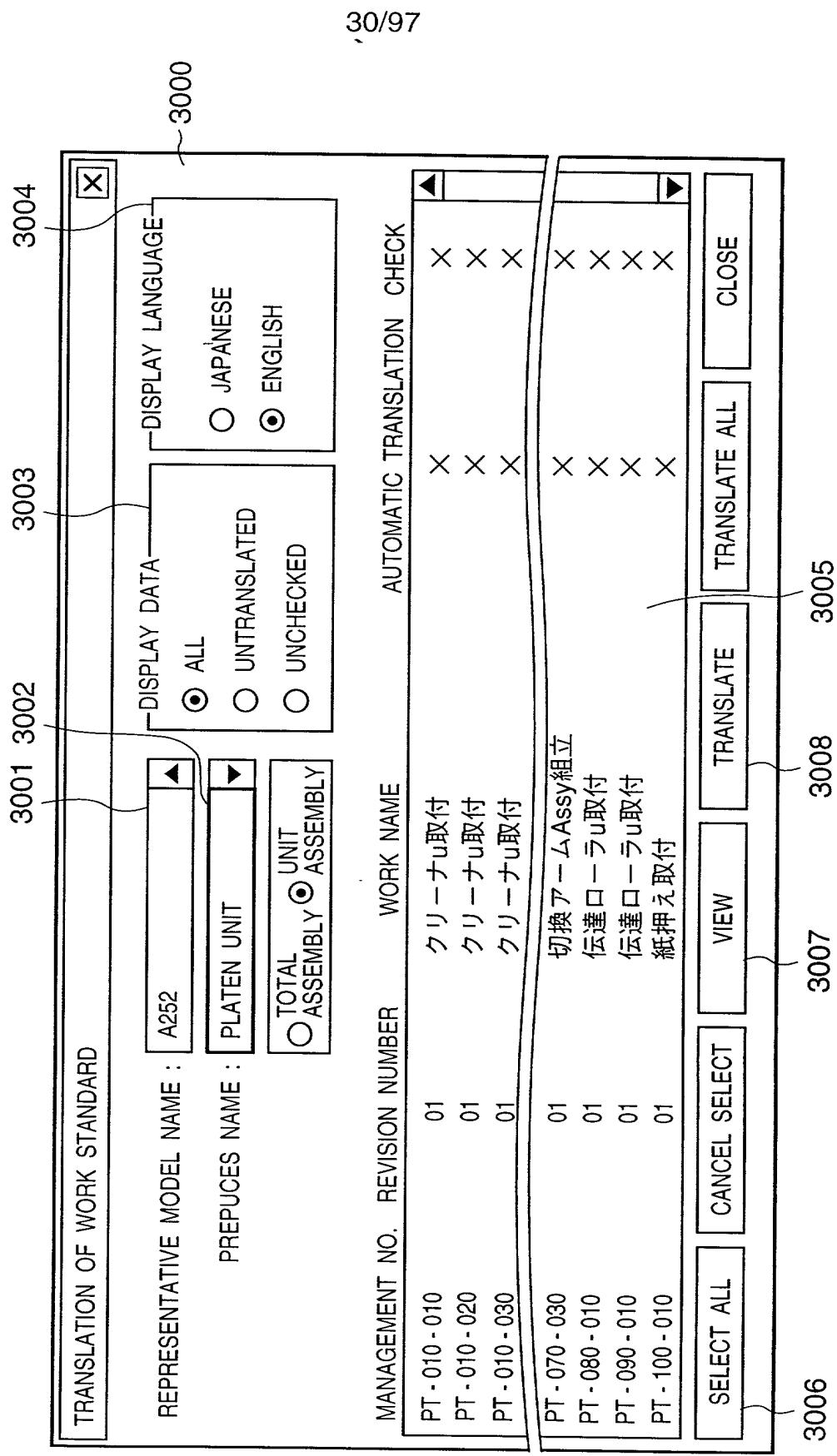


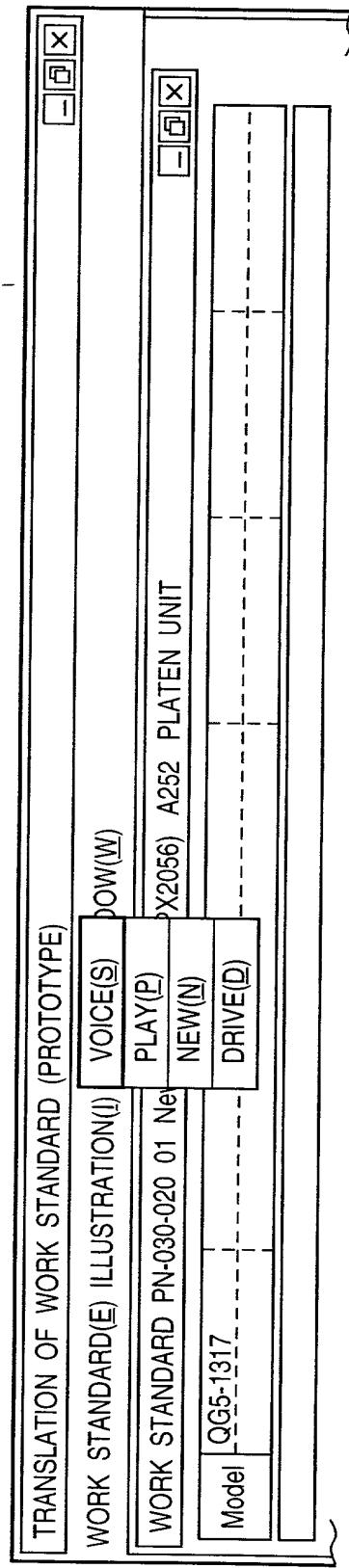
FIG. 31

FIG. 32

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WORK PROCEDURE	<input type="checkbox"/>
VOICE(W)	
JAPANESE	
WORK PROCEDURE	
フ"レ-ト"レバ"バネをブレ-ト"レバ"-の ① 部に引つ掛ける	
3201	3200
01 フ"レ-ト"レバ"バネをブレ-ト"レバ"-の ① 部に引つかける	
02 ブ"レ-ト"レバ"-を矢印ー ② 方向にスライドさせ引っ掛けり無くバ"ネ力で戻ることを確認する	
03 ブ"レ-ト"レバ"-軸先端がブ"レ-ト"ホルタ"ー先端まで圧入されていることを確認する	
3202	
ENGLISH	
Procedure	
The blade lever spring hooks to ① of the blade lever.	
3203	
01 The blade lever spring hooks to ① of the blade lever.	
02 Side the blade lever in the direction of arrow ② and there is no catch and n....	
03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....	
3204	◀ ▶
TRANSLATE	<input type="checkbox"/>
OK	<input type="checkbox"/>
CANCEL	<input type="checkbox"/>

FIG. 33



F I G. 34

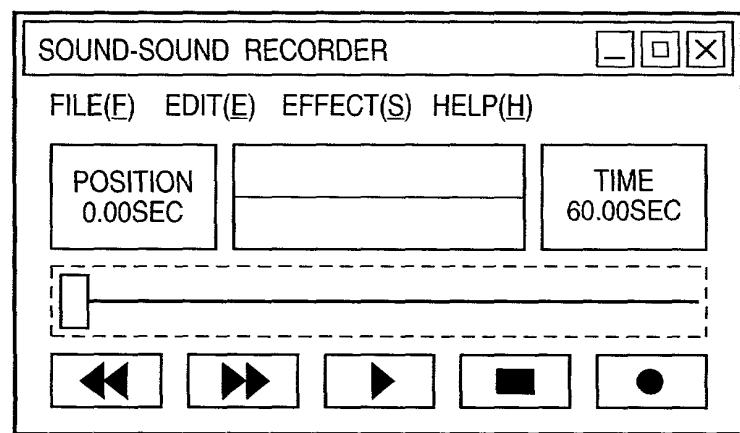


FIG. 35

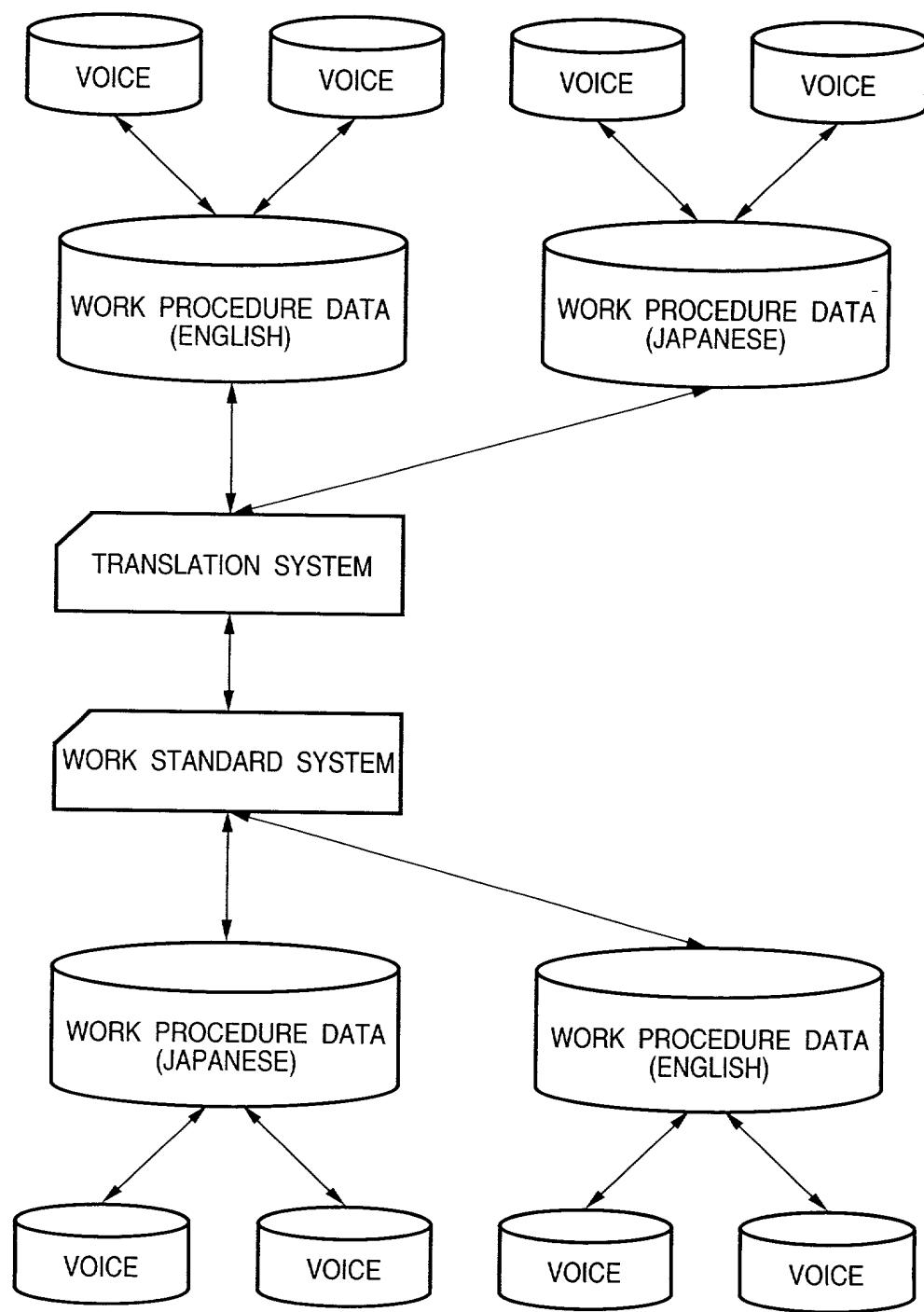


FIG. 36

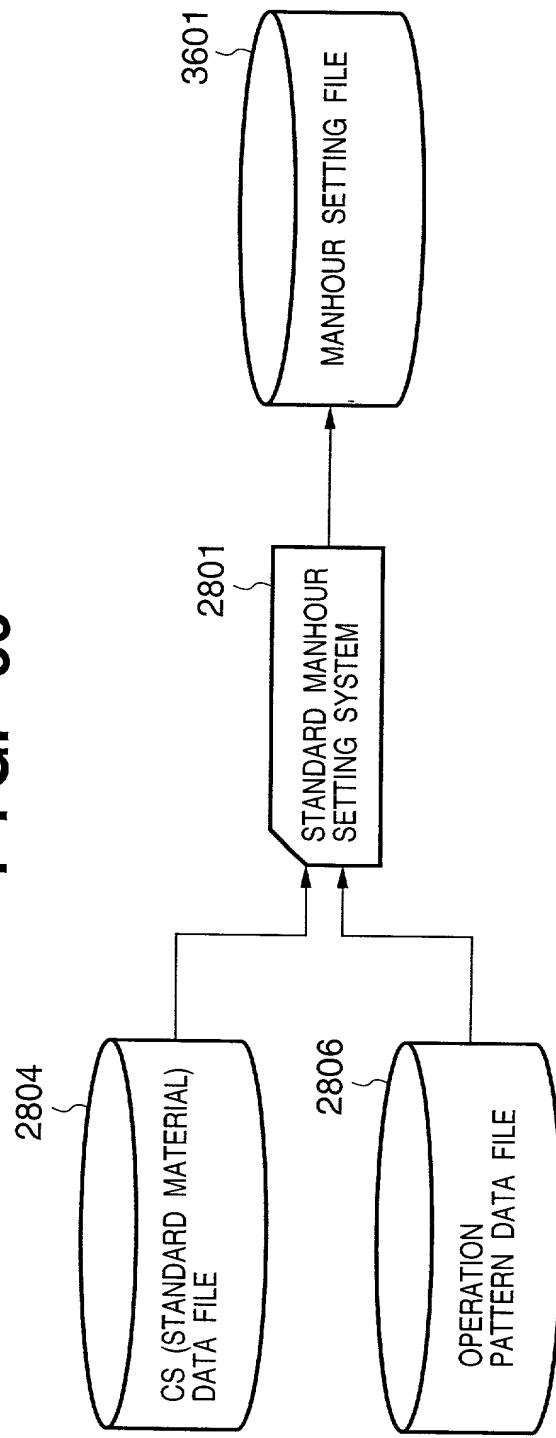


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY	MANHOUR	CS	SET CONDITION

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

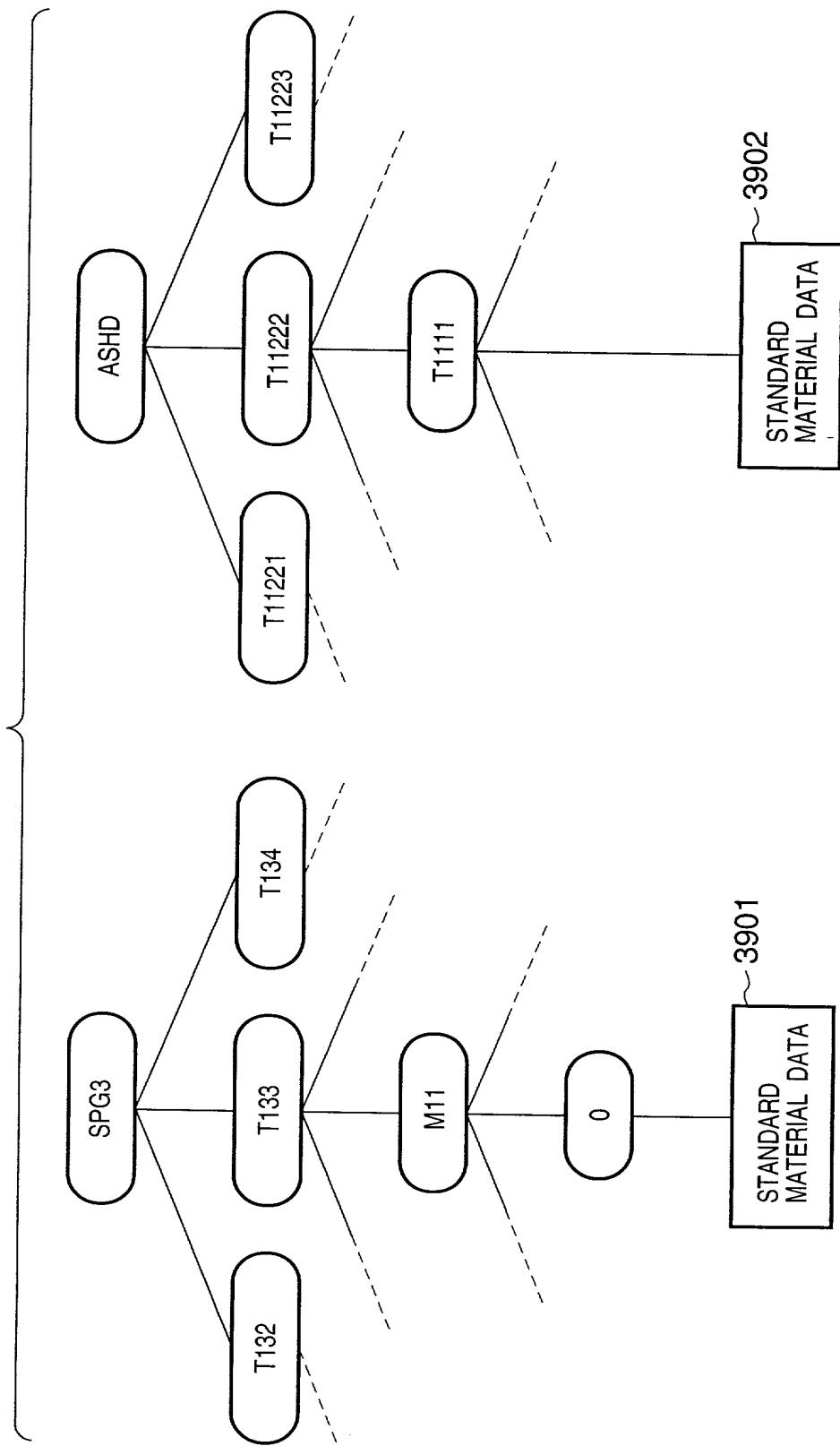


FIG. 40

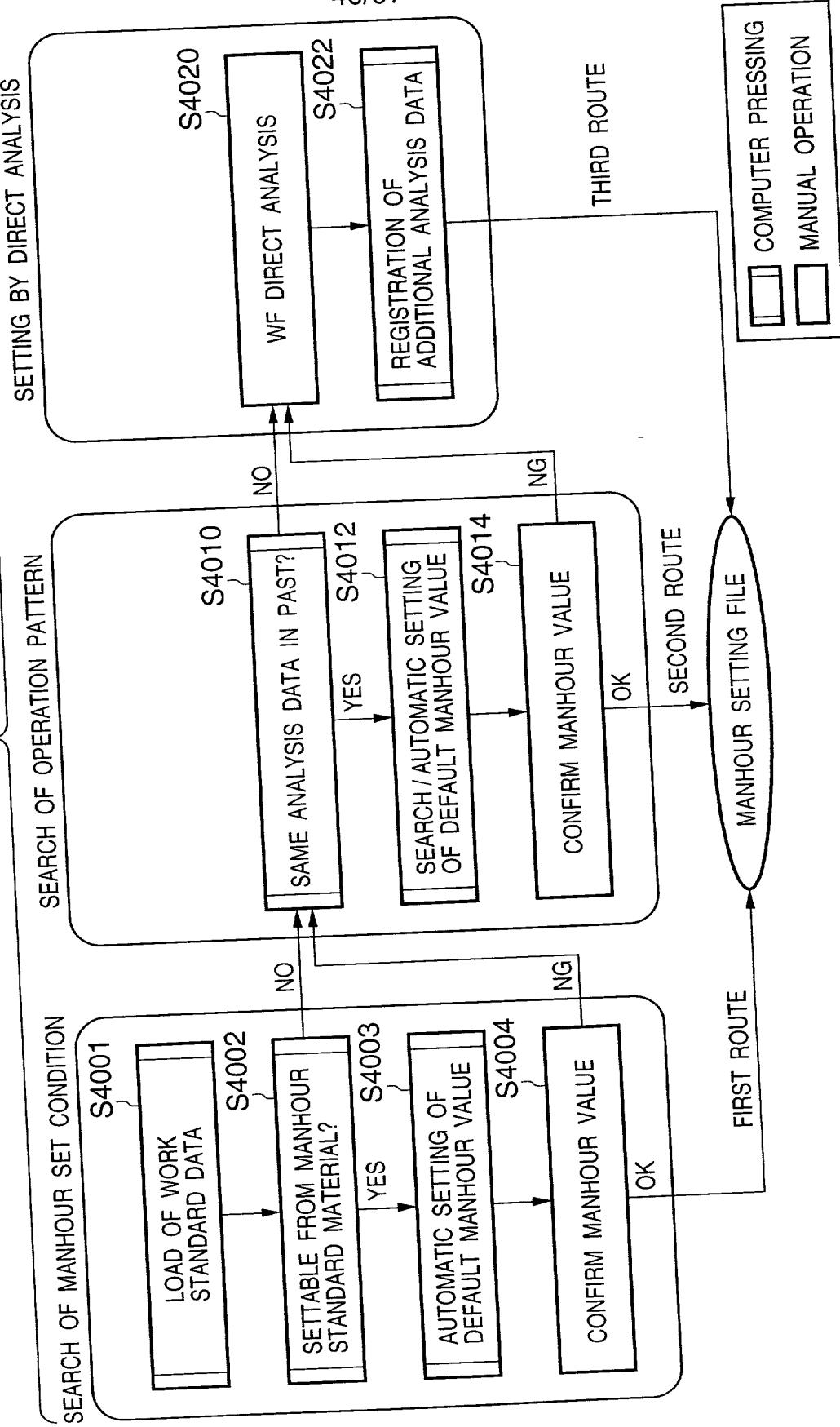


FIG. 41

3601

DATA LOAD

• ELEMENT WORK NAME

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷バネを	負荷バネ取付治具に	組込む
2	治具の	SWを		ONする
3		分離ローラ軸を	負荷バネ取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ローラ軸を	治具より	外す

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FIG. 42

3601

SEARCH KEYWORD(KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	*バネを	*に	組込む	SPG3 T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ T2111 / T111111	16RU
4	*	*Eリンク [®] を	*	組込む	RIN2 T11211 / SO	76RU
5	*	*コネクタを	*	差し込む	CONN T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6 M211 / 1	23RU

2804 ↗

FIG. 43

3601

MATCH

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	治具の	SWを		ONする	/GET:-50E/M:-10E	8RU
2	治具の	SWを		OFFする	/GET:-50E/M:-10E	8RU
3		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
4		CRGドアを		閉める	/GET:-50E/M:-50E	10RU
5		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
6		電源コードを		抜く	/GET:-50EGr2/M:-10E	16RU
7		測定用電源コードを		抜く	/GET:-50EGr2/M:-10E	16RU

3601

FIG. 44

FIG. 45

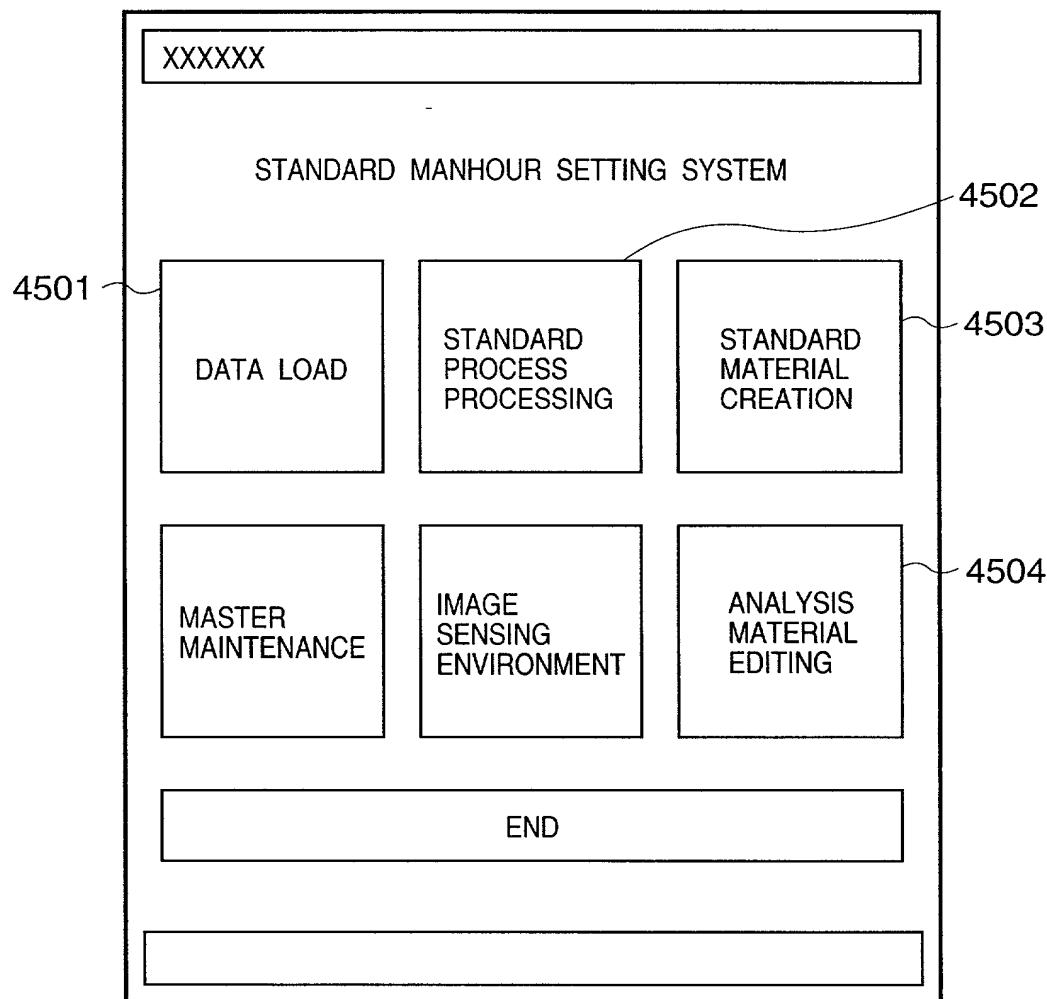


FIG. 46

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PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0 - CLOCK	XXXX	XX	XXXX	XXX
XXXXXX	BL - OLD	SET IN 1996		
xyz - test				
test - 01				
test - AMI				

4601

4602 4603 4604 4605

4609 4610

4611

4612

XXXXXX

© ALL O DESIGNATE :

PRODUCT NUMBER :

NAME :

OK

SELECT

CANCEL

FIG. 47

FIG. 48

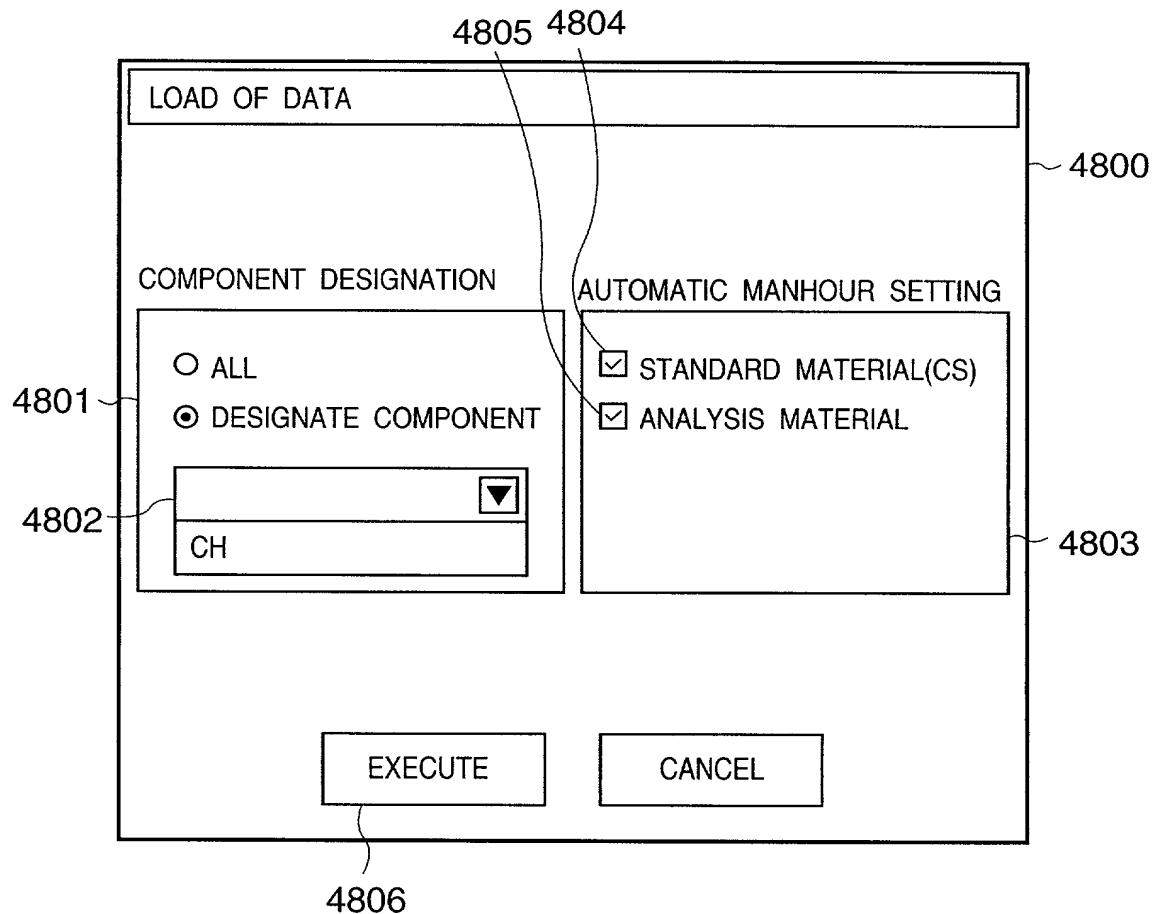


FIG. 49

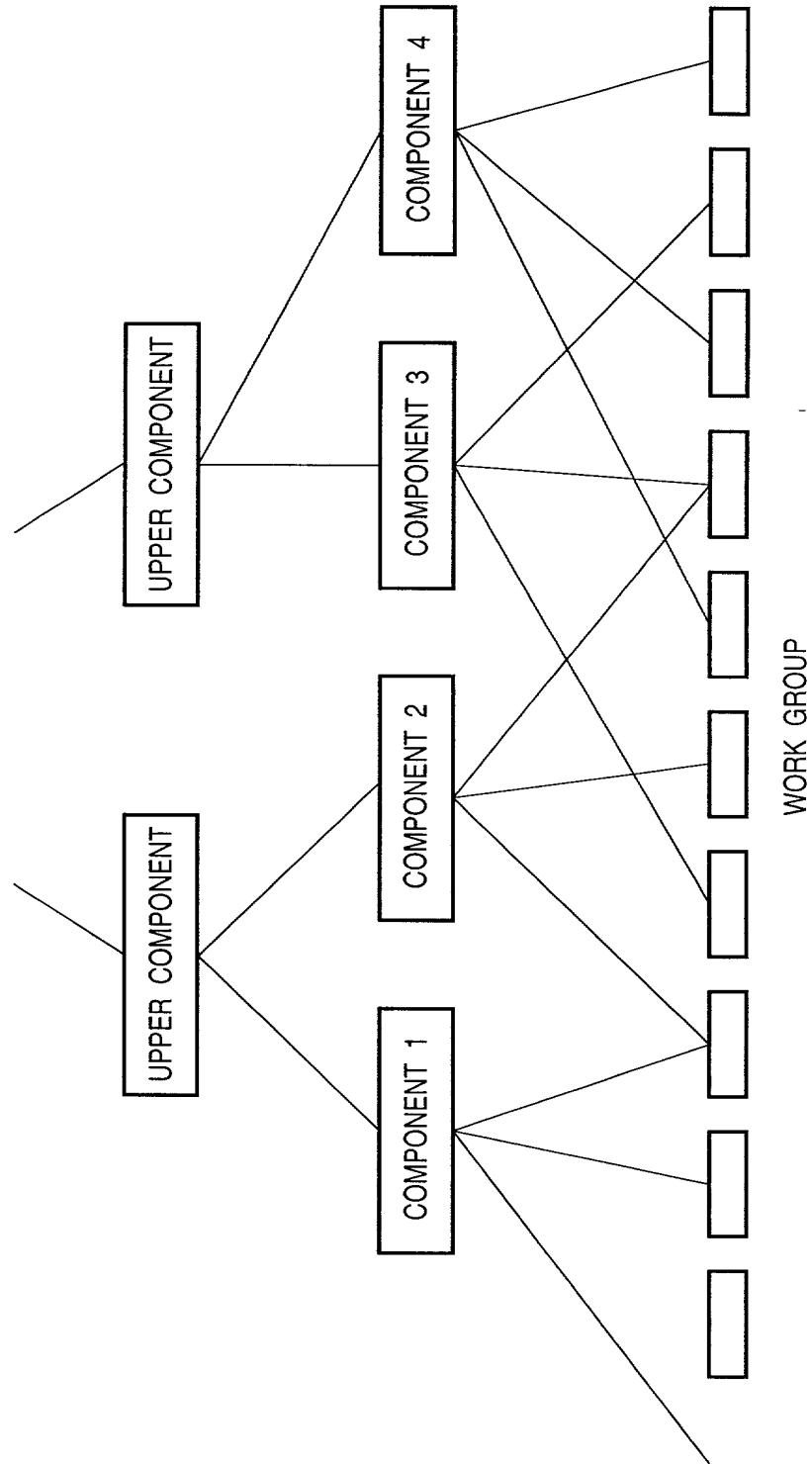


FIG. 50

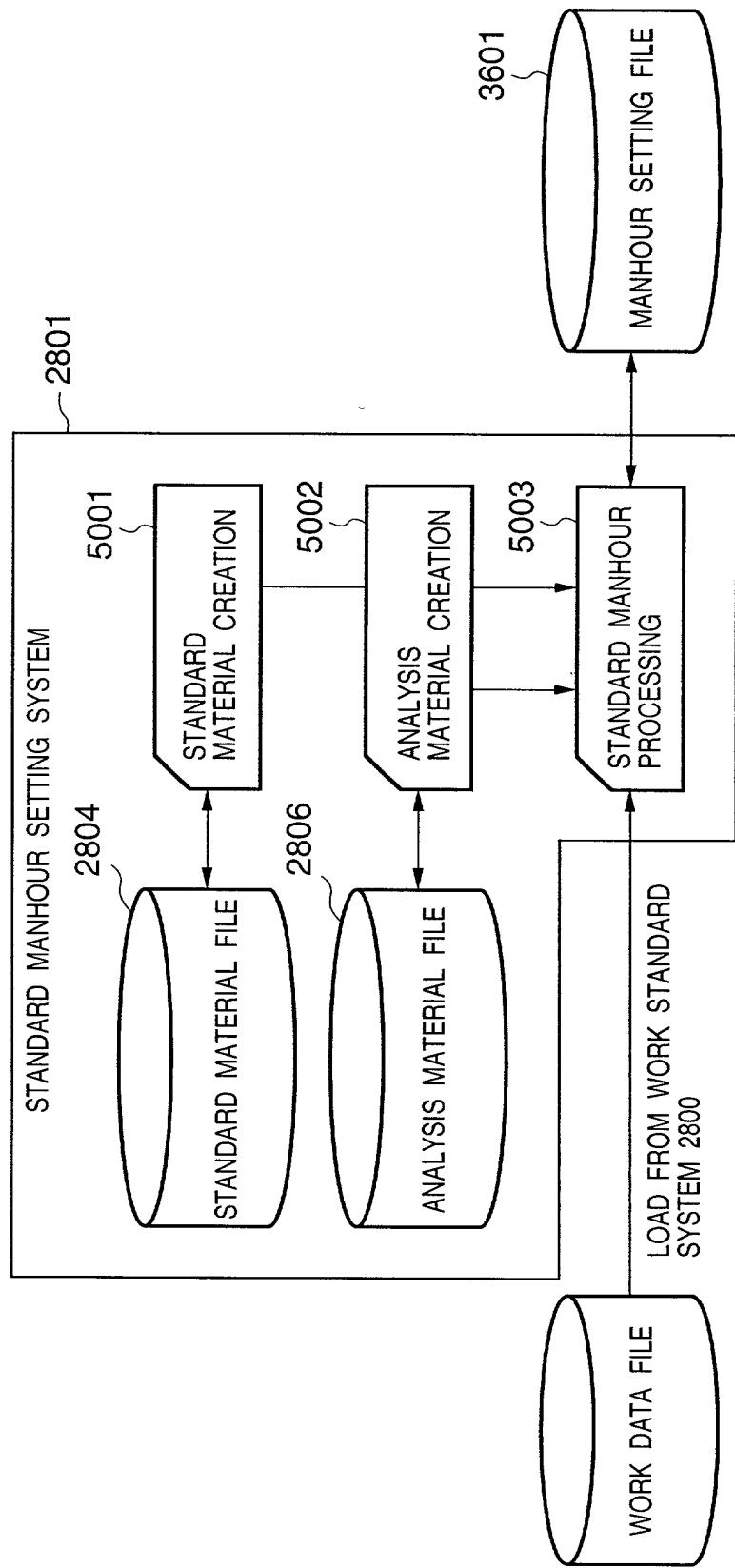


FIG. 51

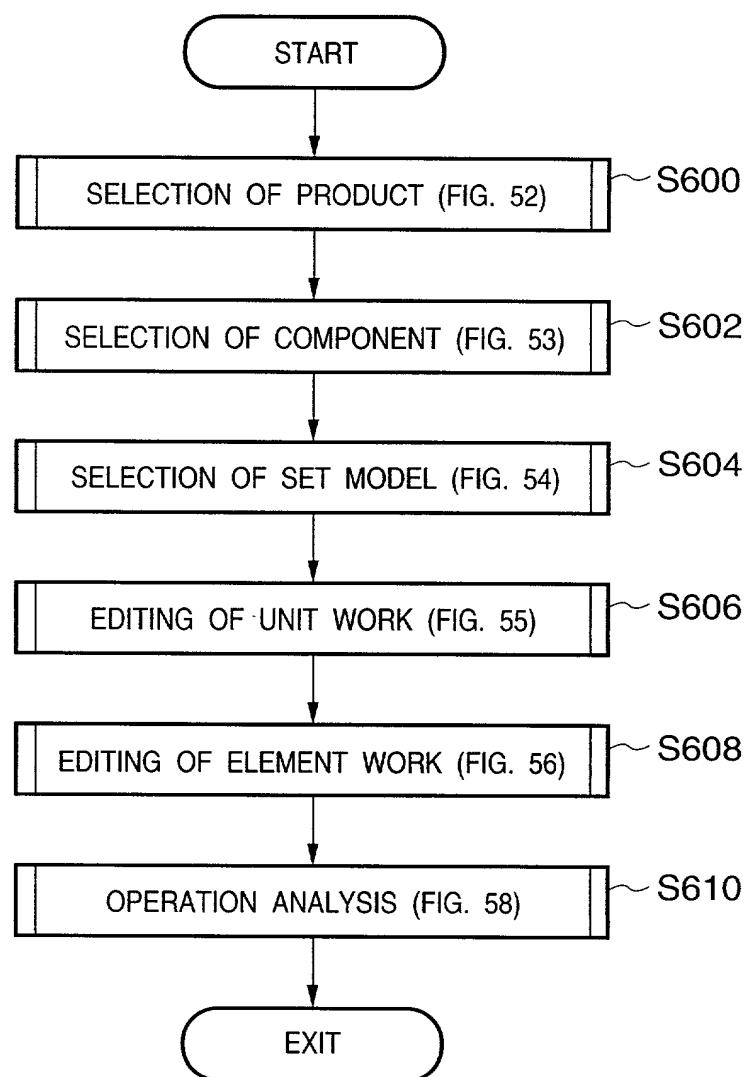


FIG. 52

FIG. 53

SELECTION OF COMPONENT													
FILE(F) EDIT(E)													
<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>													
PRODUCT SYMBOL : BJ - 4200													
NAME : BJ - 4200													
<table border="1"> <thead> <tr> <th>COMPONENT SYMBOL</th> <th>NAME</th> <th>PREVIOUS UPDATE DATE</th> </tr> </thead> <tbody> <tr> <td>► BK</td> <td>XXXXX</td> <td>1997/09/22 11:09:59</td> </tr> <tr> <td>CH</td> <td>CHECK PROCESS</td> <td>1997/09/12 11:09:59</td> </tr> <tr> <td>KO</td> <td>PACKAGE</td> <td>1997/09/18 11:21:07</td> </tr> </tbody> </table>		COMPONENT SYMBOL	NAME	PREVIOUS UPDATE DATE	► BK	XXXXX	1997/09/22 11:09:59	CH	CHECK PROCESS	1997/09/12 11:09:59	KO	PACKAGE	1997/09/18 11:21:07
COMPONENT SYMBOL	NAME	PREVIOUS UPDATE DATE											
► BK	XXXXX	1997/09/22 11:09:59											
CH	CHECK PROCESS	1997/09/12 11:09:59											
KO	PACKAGE	1997/09/18 11:21:07											
<input type="checkbox"/> DOWNLOAD <input type="checkbox"/> UPLOAD <input type="checkbox"/> BACK UP <input type="checkbox"/> LIST <input type="checkbox"/> CANCEL ACCESS FLAG <input type="checkbox"/> END													

FIG. 54

SELECTION OF MODEL			
FILE(E) EDIT(E) VIEW(V)			
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PRODUCT NUMBER : BJ - 970909		NAME : 97 - 09 - 09 LOAD	
COMPONENT SYMBOL : CH		NAME :	
SET	MODEL SYMBOL	QUANTITY	NAME
►	A250 1Q		
	BJC - 4200LX		
	BJC - 4200 SYSTEM		
	BJC - 420J		
	BJC - 420J(BLACK)		
	BJC - 4300		XXXX
	BJC - 430J		1997/09/09 10:46:33

FIG. 55

SELECTION OF MODEL											
FILE(E) EDIT(E) VIEW(V)											
<input type="checkbox"/>	<input type="checkbox"/>										
PRODUCT SYMBOL : BJ - 970909 NAME : 097 - 09 - 09 LOAD SET MODEL SYMBOL : BJC - 4300											
COMPONENT SYMBOL : ON NAME : NAME : x x x x x											
LATEST' REVISION NUMBER											
UPDATE DISPLAY											
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY				
► N	3	CH-01-01	1	電気チエック	0	0	0				
N	4	CH-01-02(1)	1	電気チエック	0	0	0				
N	5	CH-01-02(2)	1	電気チエック	0	0	0				
N	6	CH-01-03	1	電気チエック	0	0	0				
N	7	CH-01-04	1	電気チエック	0	0	0				
N	23	CH-07-02(1)	1	フロントカバー取り付	0	0	0				
N	24	CH-07-02(2)	1	フロントカバー取り付	0	0	0				
N	25	CH-07-01(3)	1	フロントカバー取り付	0	0	0				
N	26	CH-07-01(4)	1	フロントカバー取り付	0	0	0				
No. FORMAL MANAGEMENT NO.		UNIT WORK NAME	MANHOUR	USE	FREQUENCY	1	2	3	4	5	
3	CH-01-01	ELECTRICAL CHECK	0	0	0						
◎ CHANGE O INSERT O ADD		OK									
5501	5507	5506	5502	5503	5504	5505					

FIG. 56

XXXXXX							
FORMAL MANAGEMENT NO. PU-03-01 UNIT WORK NAME : MOTOR ATTACHMENT							
TOTAL MANHOUR: <input type="text" value="0"/> NEXT UNIT WORK							
NO.	ELEMENT WORK NAME	REVISION	MANHOUR	USE	CS	SET CONDITION	
► 1	LFFタのケーブルと反対側の軸にタグキア	1	0	0			
*							
COMMENT 1 : LFFタのケーブルと反対側の軸に							
OBJECT :	タグキアを						
COMMENT 2 :	ギア径の小さい方から						
VERB :	取ける <input type="text" value="設定"/>						
5604 5605 5603 5602 5601							

FIG. 57

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EDITING OF ANALYSIS MATERIAL									
FILE(E) EDIT(E) VIEW(V)									
PRODUCT GENRE : <input type="text" value="ALL"/> <input type="button" value="▶"/>									
TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR USE	FREQUENCY COUNT	SET	DATE
▶	I7-キャラッ°：	本体を	矢印1の様に	入れる	-50/Gr1/N>6/-3	15	0 1 1	0	97/09/09 9:52
	I7-キャラッ°：	本体を	矢印1の様に	入れる	-50/E/02/N/-6	11	0 1 1	0	97/09/09 9:53
	I7-キャラッ°：	本体を	矢印1の様に	入れる	-50/Gr1/N>6/-3	15	0 1 1	0	97/09/09 9:55
	要素作業01		動詞		-50/Gr1/N>6/-3	15	0 1 1	0	97/09/10 16:34
	I7-キャラッ°：	本体を	矢印1の様に	入れる	-50/Gr1/N>6/-3	15	0 1 1	0	97/09/10 19:09
	キャラッ°ロック		塗布する		Time100/Rate100	100	1 1 1	1	97/09/10 19:16
	モタ-組立る：	プリンシャーフ	入れ、セットする		M211/1/10	50	1 1 1	1	97/09/11 17:00
	プリンシャーフ		裏面にする		T1221/M2311/0/0	12	0 1 1	0	97/09/11 17:34
1		1			T2221/M1211/0/1	24	0 1 1	0	97/09/11 17:20
2		2			T1221/M2311/0/0	12	0 1 1	0	97/09/11 17:24
	プリンシャーフ	PRカ"イド"取付る	セットする			15	0 1 1	0	97/09/11 17:24
	ggdfafdfas		fdastdfastdfast	*		16	0 1 1	0	97/09/12 11:24
	dsdffffdsdsaf		fdsafdfaddfds		T21121/M1111/0/1	13	0 1 1	0	97/09/12 12:10
	dgdfafdfas		fdastdfastdfast	*		16	0 1 1	0	97/09/12 12:10
	プリンシャーフ	PRカ"イド"取付る	セットする			15	0 1 1	0	97/09/12 13:39
	プリンシャーフ	PRカ"イド"取付る	セットする			15	0 1 1	0	97/09/12 14:00
	プリンシャーフ	PRカ"イド"取付る	セットする			15	0 1 1	0	97/09/12 14:00
	プリンシャーフ	セットする			Time100/Rate100	100	1 1 0	0	97/09/12 14:04

FIG. 58

OPERATION ANALYSIS		5801		5802		5803		5804		5805			
													
1 SET MAIN BODY TO PREDETERMINED POSITION		TOTAL SIMO VALUE: 0		TOTAL MANHOUR VALUE: 0		TOTAL MANHOUR VALUE: 15		SIMO		NEXT ELEMENT WORK			
NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOUR	USE	REMARKS							
▲	1 XXXXXX	PU	-60/Gr1/N>6/-3	15	0								
*													

FIG. 59

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5901	<input type="radio"/> 1. PU	<input type="radio"/> 6. DSY	<input type="radio"/> 11. PU	<input type="radio"/> 16. DSY
	<input type="radio"/> 2. GET	<input type="radio"/> 7. R	<input type="radio"/> 12. GET	<input type="radio"/> 17. R
	<input type="radio"/> 3. M	<input type="radio"/> 8. UMAC	<input type="radio"/> 13. M	
	<input type="radio"/> 4. MA	<input type="radio"/> 9. MP	<input type="radio"/> 14. MA	
	<input type="radio"/> 5. ASY	<input type="radio"/> 10. BODY	<input type="radio"/> 15. ASY	

SIMO SELECT CANCEL

5902

FIG. 60

XXXXXX	PICK UP	MANUAL				
1 : MOVING DISTANCE	-10cm	+10cm	>50cm	3	4	5
2 : GRIP TYPE	Qr-3	Qr-2				6
3 : PRE-POSITIONING	NO	YES				
4 : MAIN SIZE	-10mm	-6mm				
5 : WEIGHT	<3Kg	>3Kg				
6 :						
	SET	CANCEL	SET VALUE	FORMULA		
	6001	6002	6003			

FIG. 61

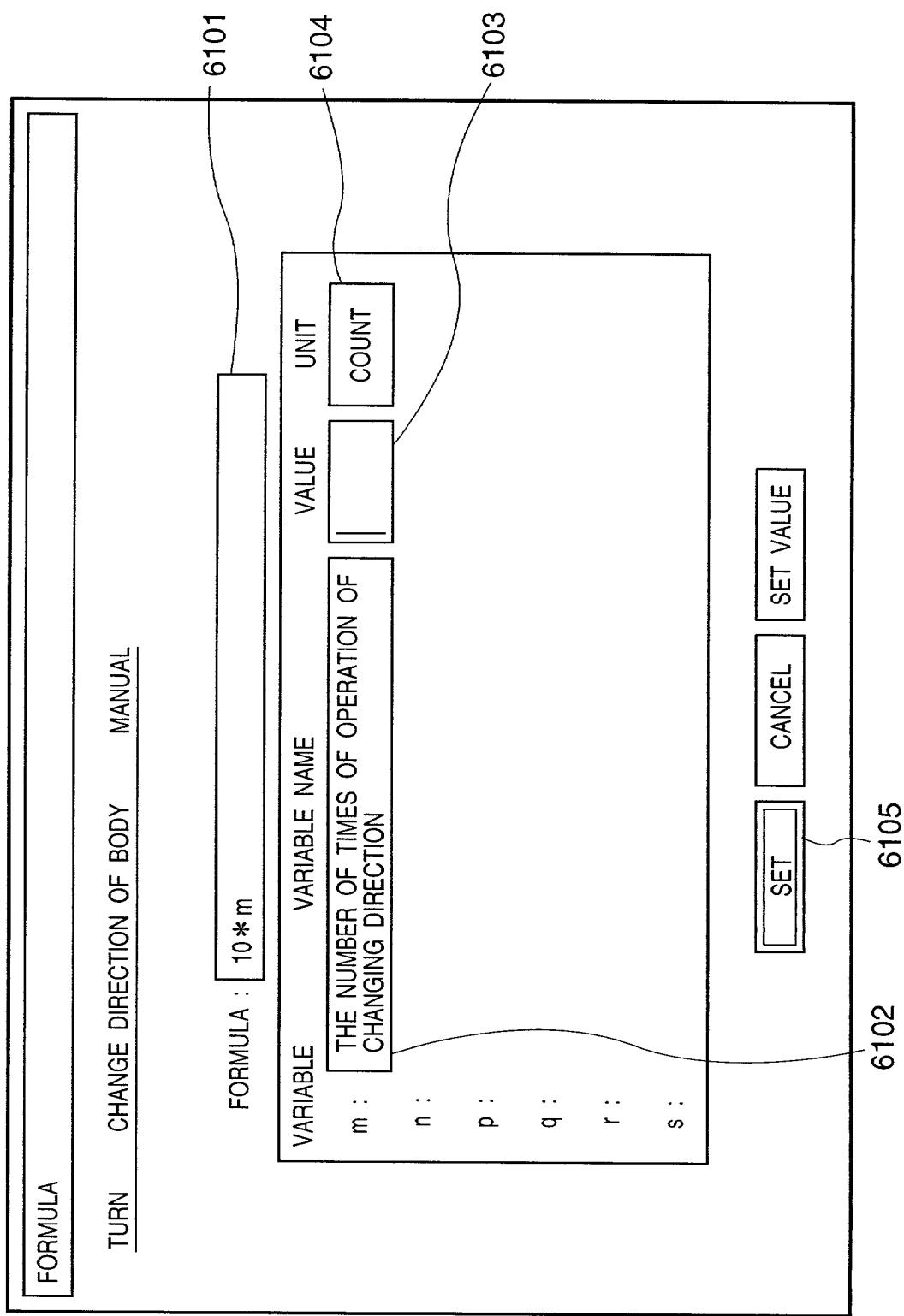


FIG. 62

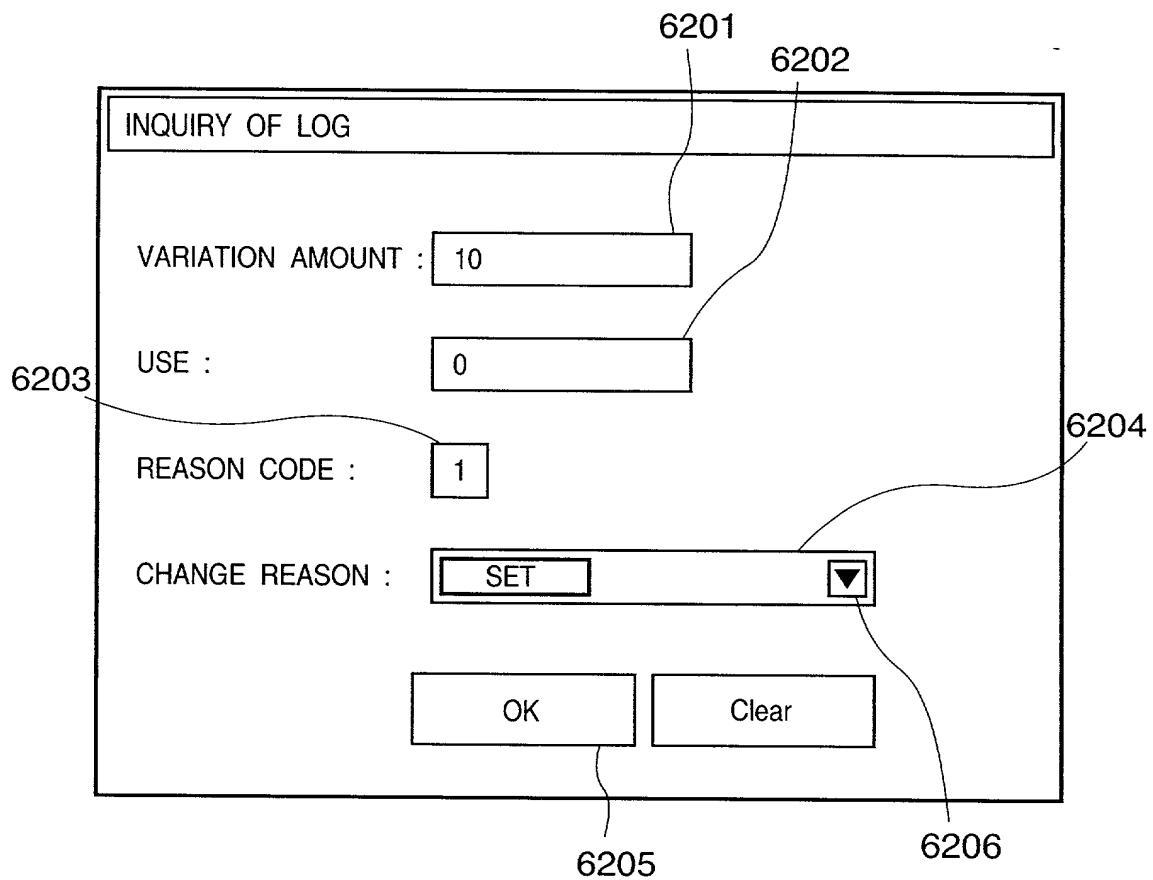


FIG. 63

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CORRECTION OF CHANGE LOG																							
6301	6302																						
DATE																							
<input type="text" value="1997"/> <input type="text" value="09"/> <input type="text" value="22"/> <input type="radio"/> = <input type="radio"/> FROM <input type="radio"/> BEFORE <input type="radio"/> ~																							
<input type="button" value="SEARCH"/>																							
<table border="1"><thead><tr><th>NO.</th><th>UNIT WORK NAME</th><th>CODE</th><th>CHANGE REASON</th><th>NEW MANHOUR</th><th>(NEW) MANUAL USE</th><th>PREVIOUS MANHOUR</th><th>(PREVIOUS) MANUAL USE</th><th>(PREVIOUS) USE</th><th>CHANGE</th><th>DATE</th></tr></thead><tbody><tr><td>► CH-01-01</td><td>ELECTRICAL CHECK</td><td>1</td><td>SET</td><td>10</td><td>0</td><td>0</td><td>0</td><td>0</td><td>1997/09/22</td><td>14.30.00</td></tr></tbody></table>		NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL USE	PREVIOUS MANHOUR	(PREVIOUS) MANUAL USE	(PREVIOUS) USE	CHANGE	DATE	► CH-01-01	ELECTRICAL CHECK	1	SET	10	0	0	0	0	1997/09/22	14.30.00
NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL USE	PREVIOUS MANHOUR	(PREVIOUS) MANUAL USE	(PREVIOUS) USE	CHANGE	DATE													
► CH-01-01	ELECTRICAL CHECK	1	SET	10	0	0	0	0	1997/09/22	14.30.00													
REASON CODE	<input type="text" value="1"/> <input type="button" value="CHANGE REASON SET"/> <input type="button" value="▼"/>																						
	<input type="button" value="OK"/> <input type="button" value="CtR"/> <input type="button" value="END"/>																						

FIG. 64

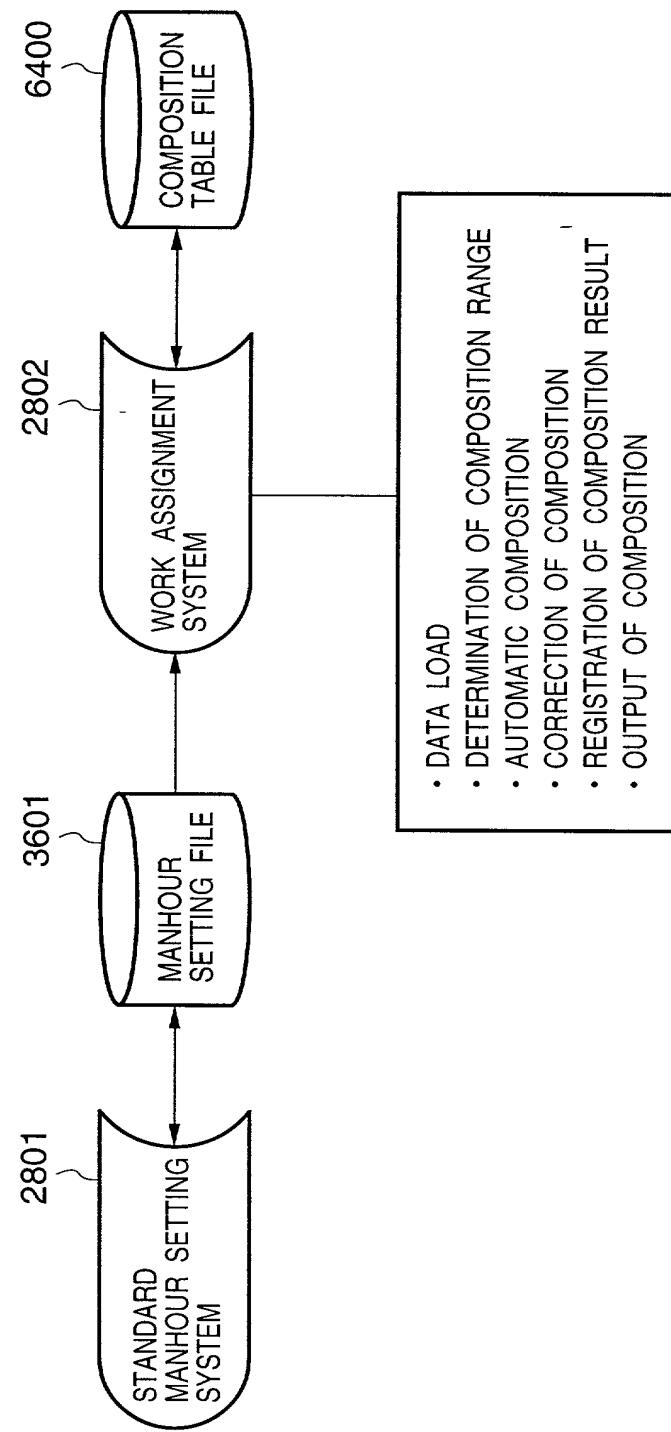


FIG. 65

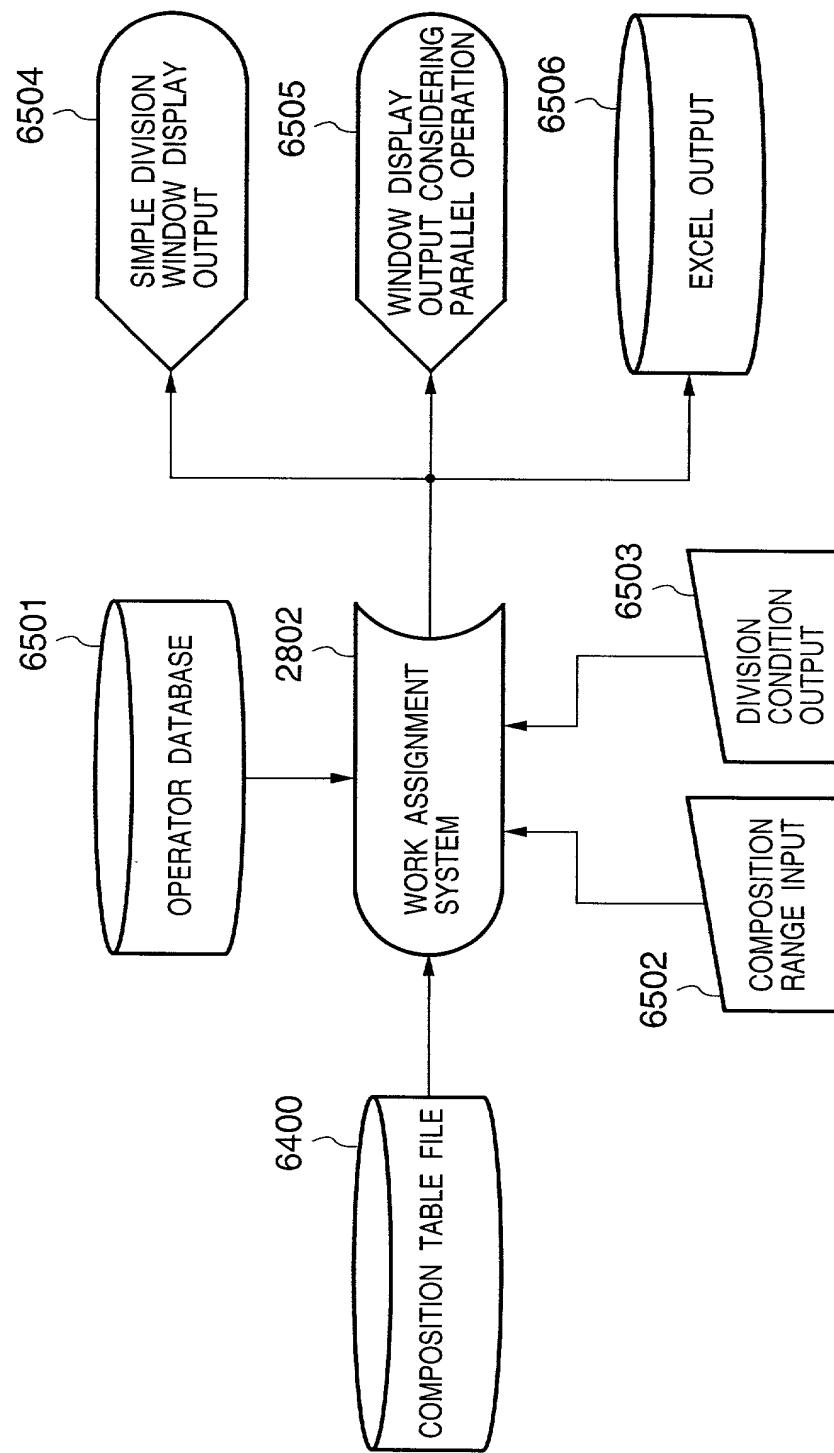


FIG. 66

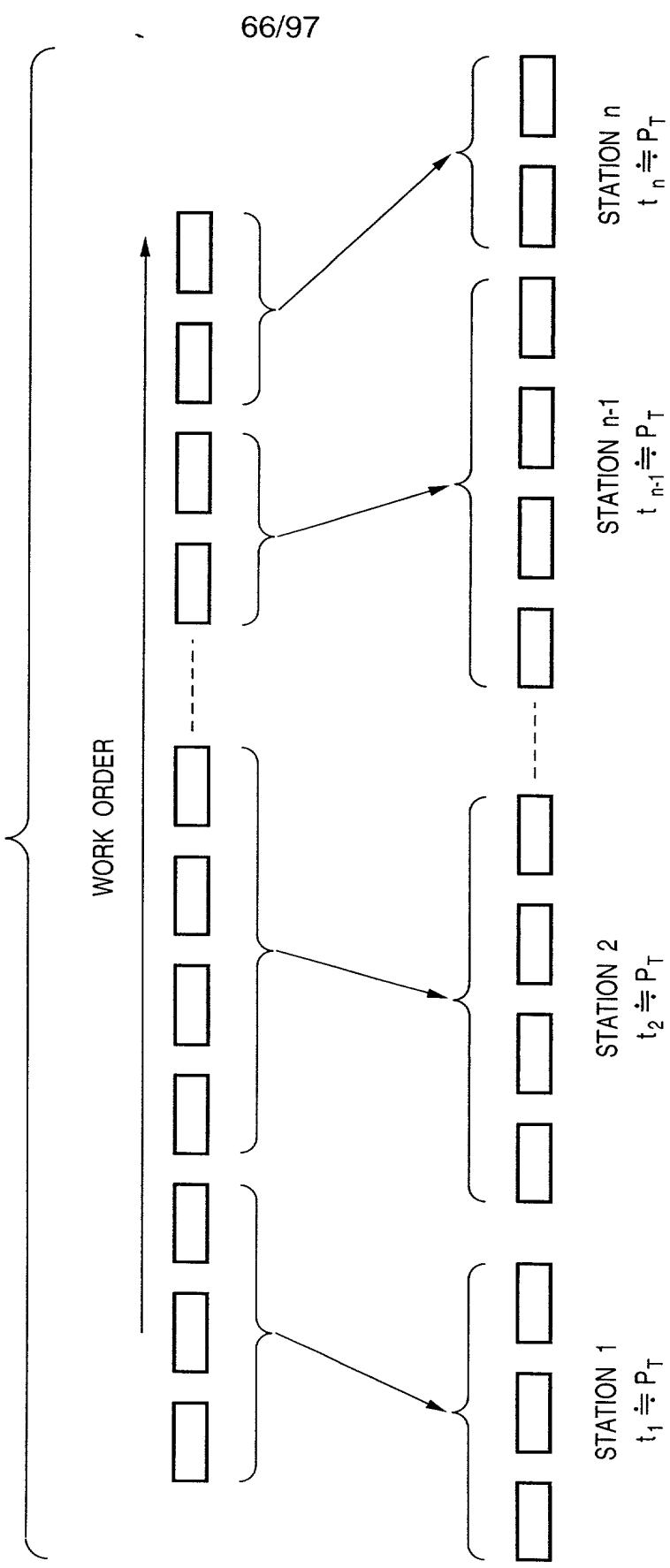


FIG. 67

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The diagram illustrates a computer terminal interface. At the top, there is a menu bar with the following options: FILE(F), EDIT(E), INPUT(I), TOOL(O), and a set of cursor control keys (up, down, left, right). Below the menu bar, there are two rectangular input fields. The first field contains the text 'GP55' and is labeled 'MODEL' to its left. The second field is empty and is labeled 'UNIT' to its left. To the right of these fields is a table with the following data:

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117
		:

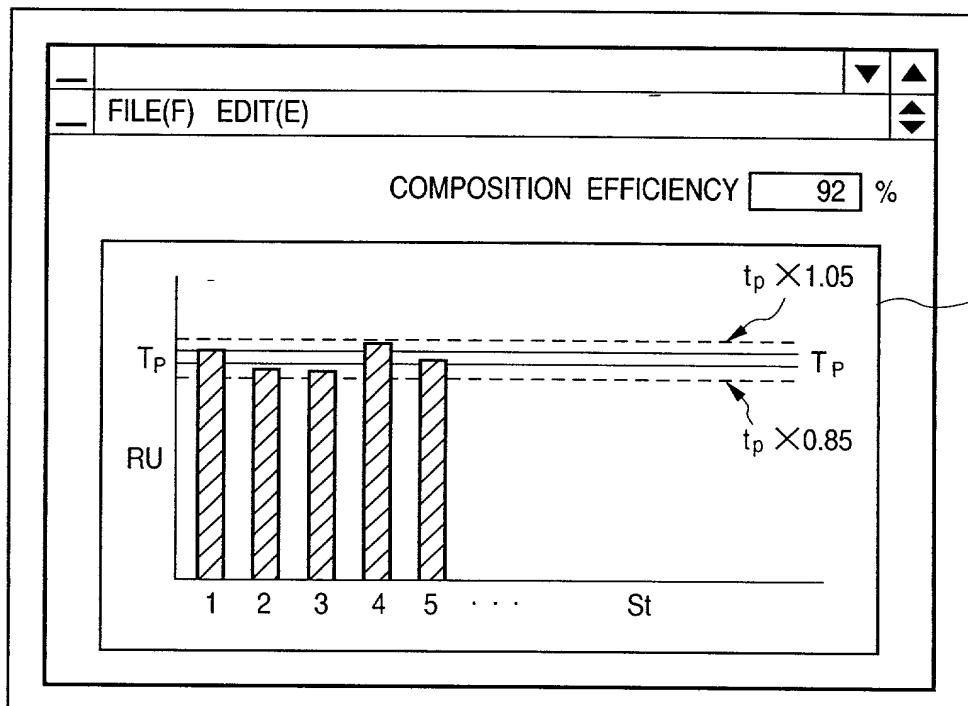
A bracket on the right side of the table groups the first three rows under the label 'SIMPLE DIVISION' and the last three rows under the label 'PARALLEL DIVISION'.

FIG. 68

SIMPLE DIVISION

—		▼	▲
—	FILE(F) EDIT(E)	◆	◆
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69



6902

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

DRAG AND DROP

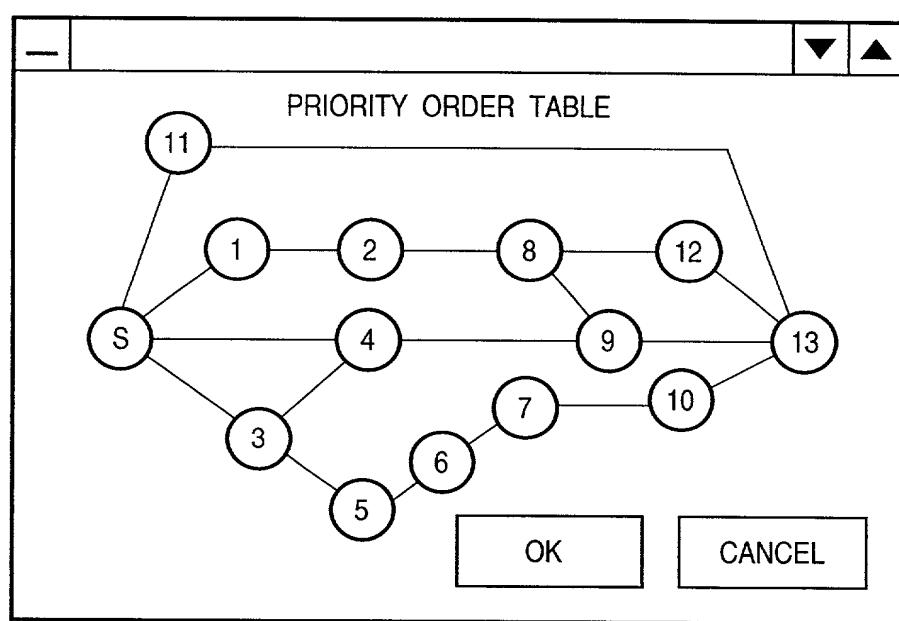
St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

OK CANCEL

6903

FIG. 70



7.1/97

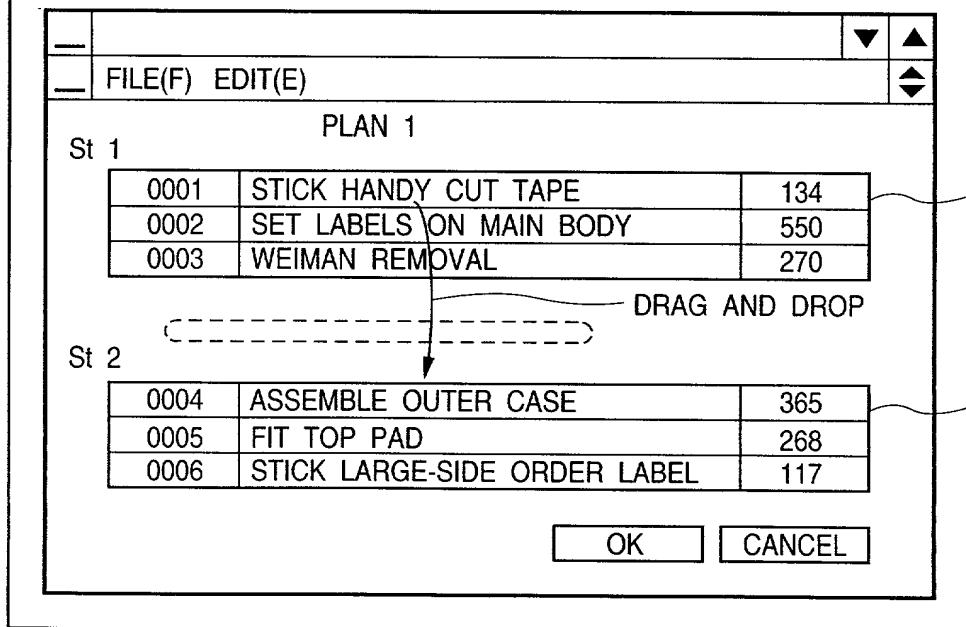
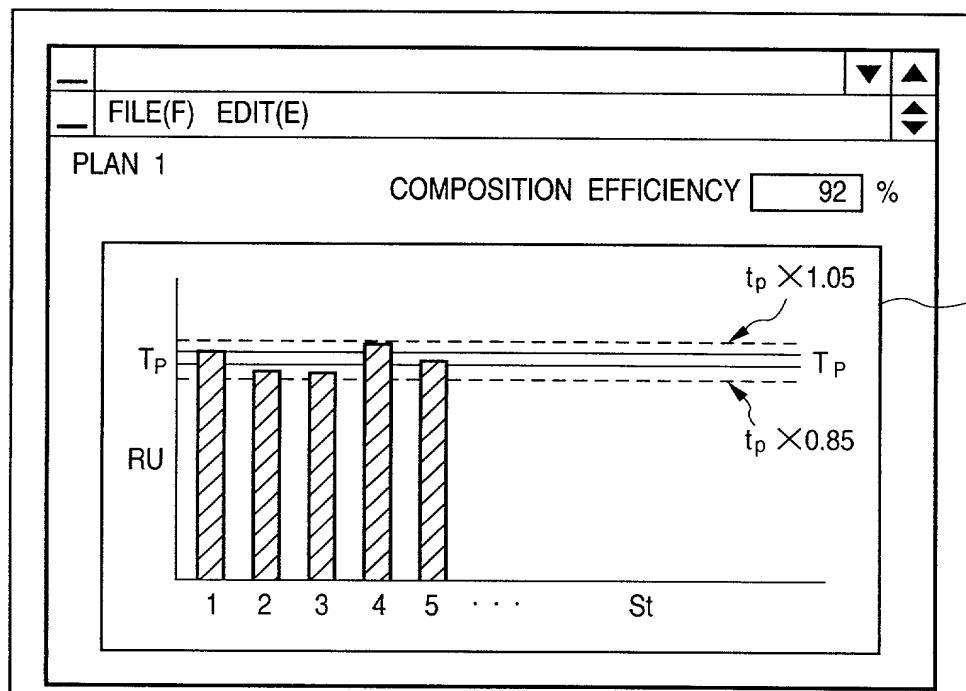
FIG. 71

PARALLEL DIVISION

PLAN 1		
St 1		
1	1 STICK HANDY CUT TAPE	
2	2 SET LABELS ON MAIN BODY	
8	3 WEIMAN REMOVAL	
St 2		
3	4 ASSEMBLE OUTER CASE	
4	5 FIT TOP PAD	
5	6 STICK LARGE-SIDE ORDER LABEL	

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FIG. 72



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FIG. 73

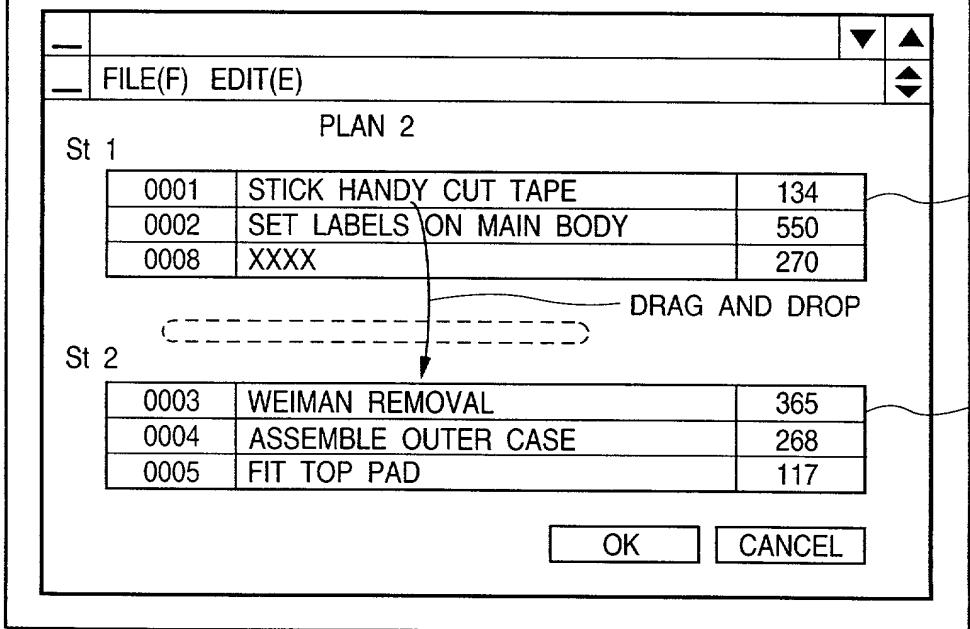
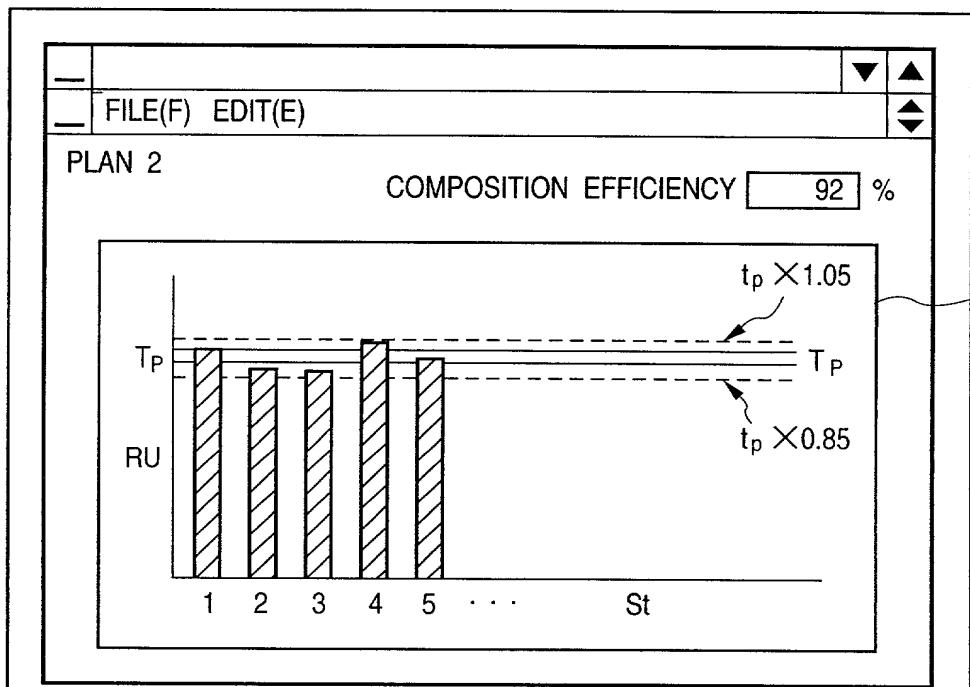


FIG. 74

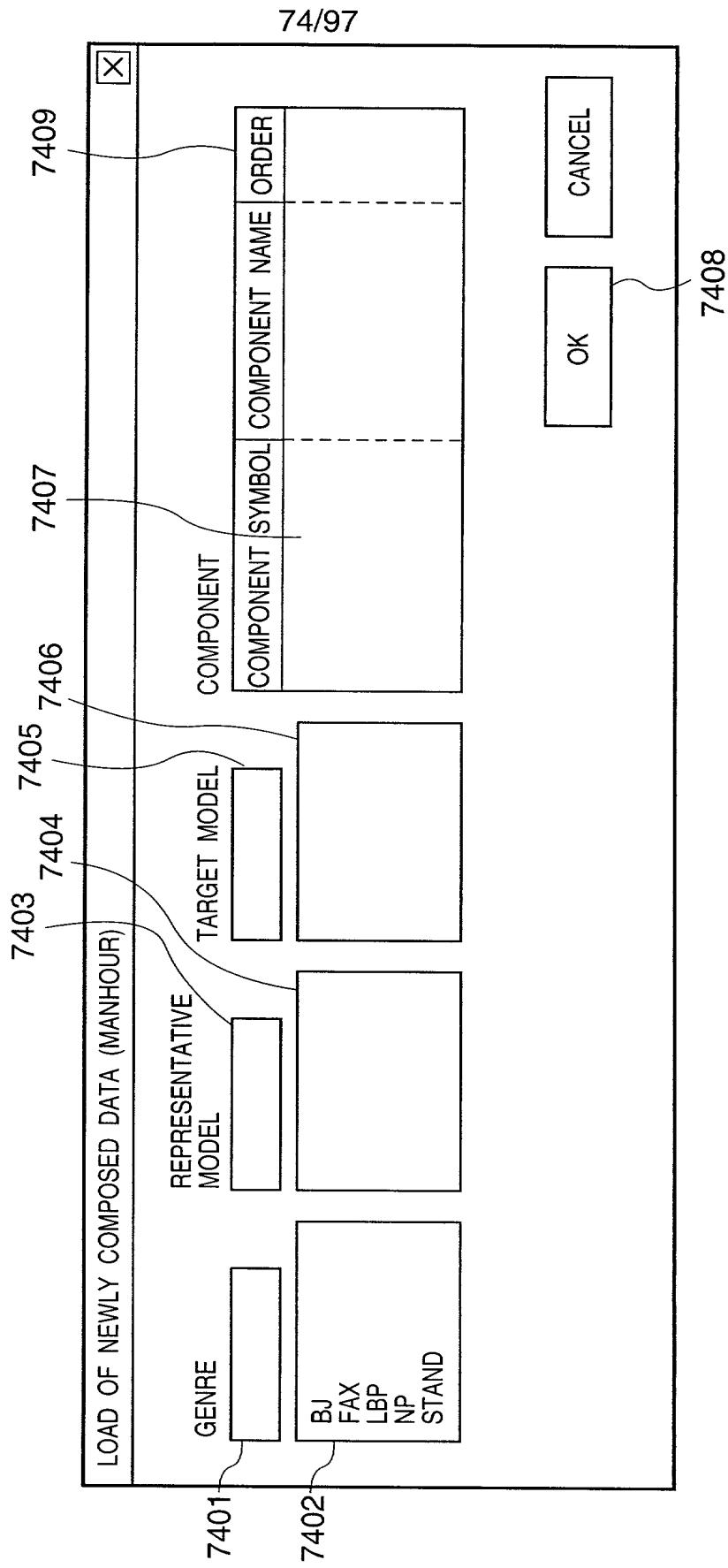


FIG. 75

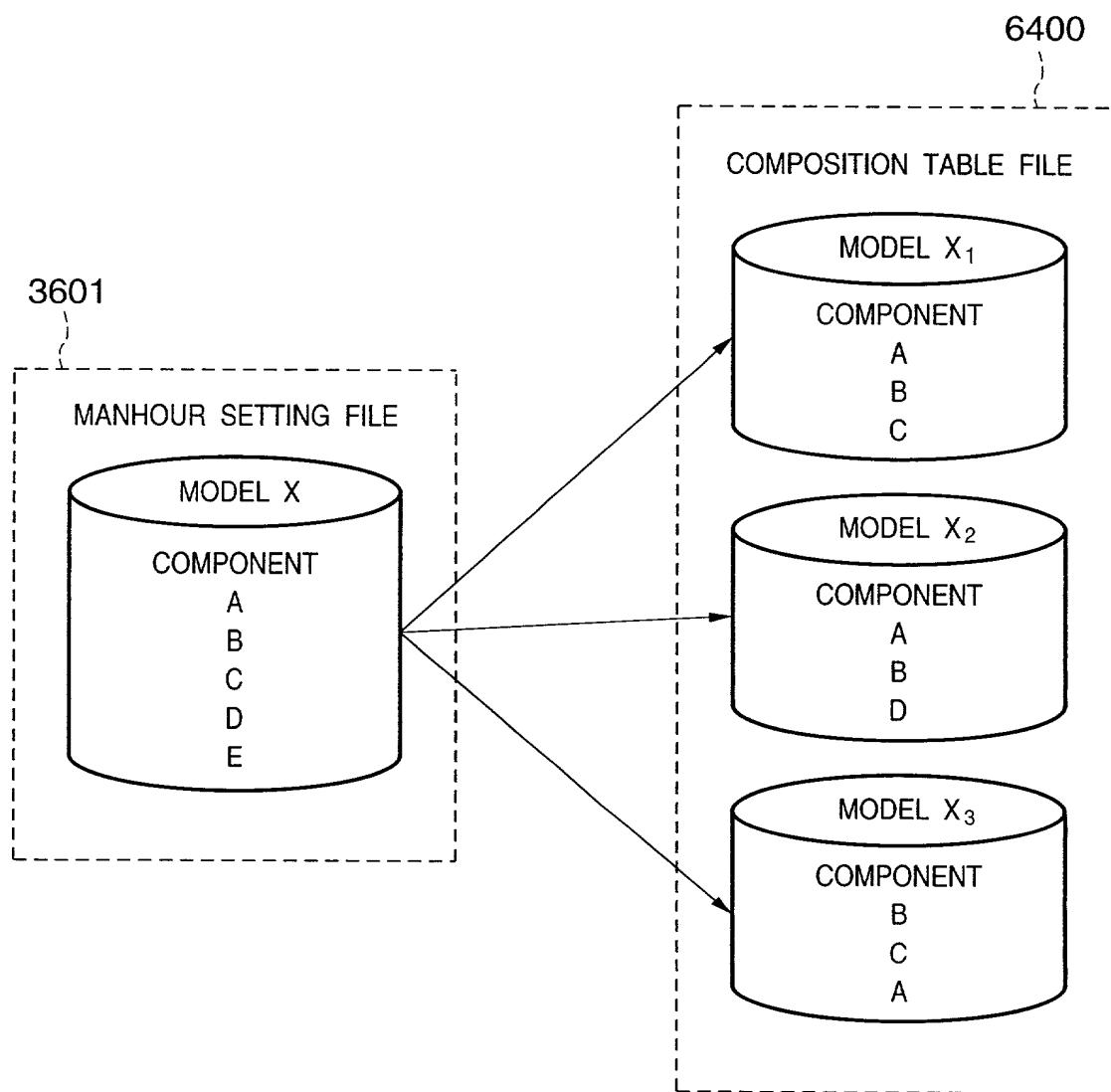
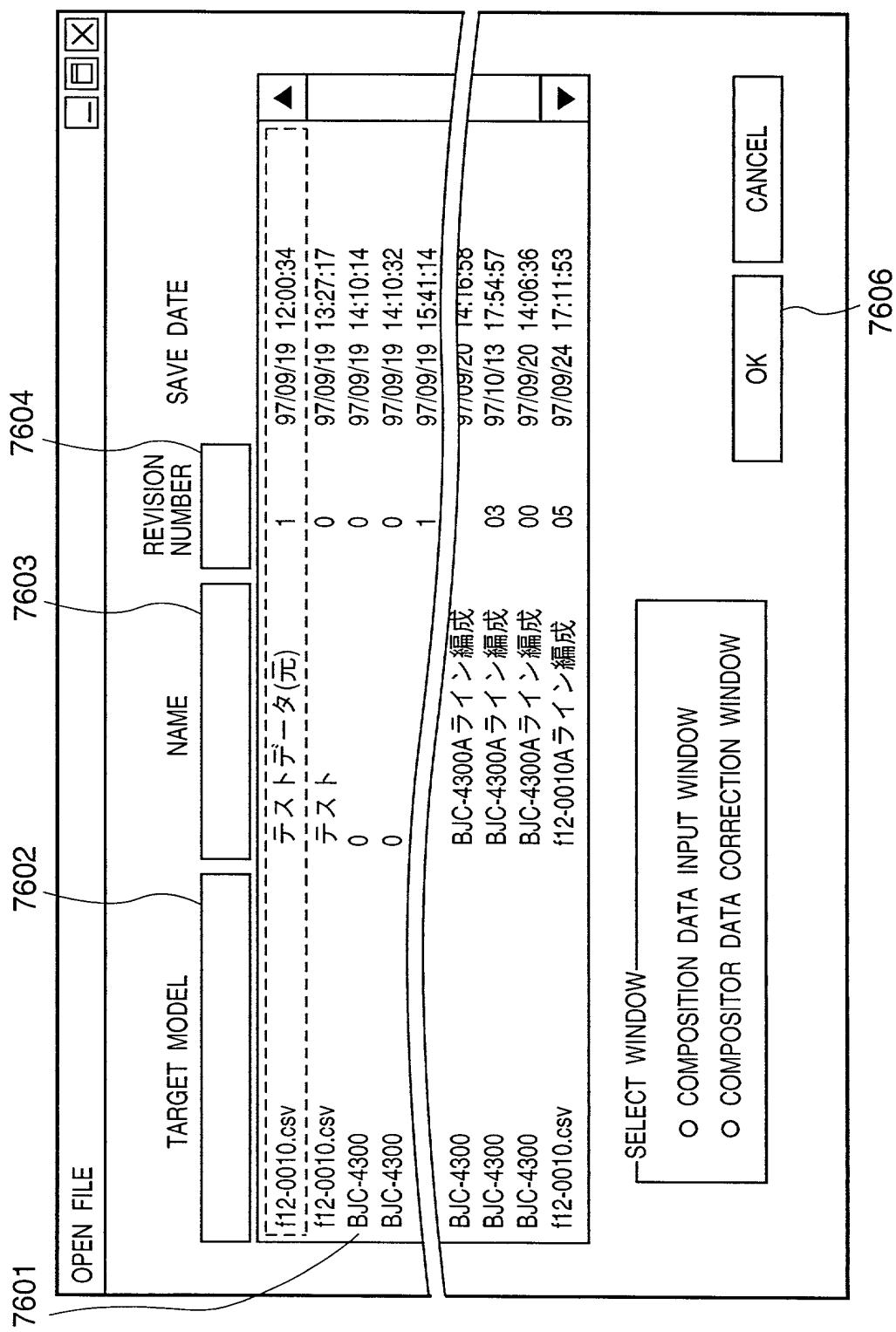


FIG. 76



7706 7701 7702 7705 7703

FIG. 77

7710

INPUT OF COMPOSITION DATA									
FILE(E)	EDIT(E)	TOOL(U)	OPTION(Q)	FILE NAME (COMPOSITION NAME)	REVISION NUMBER	G	WORK	TOOL	PART
COMPOSITION DATA									
TARGET MODEL									
PER1000									
G NO. WORK NAME UNIT NAME WORK NAME WF MANHOUR CHINE MANHOUR SECTION REMARKS									
1	1	1	1	1	1	1	1	1	1
FIRST NO.	WORK STANDARD NO.	UNIT NAME	WORK NAME	WF MANHOUR	MANUAL MANHOUR	PROVISIONAL MANHOUR	SEC. MANHOUR	COMPONENT NAME	NODE NO. PREVIOUS
1	1	9000000000000001E	単位名称s1	579	579	0	0	内 セット	1 0
1	2	9000000000000001E	単位名称s2	54	54	0	0	内 セット	2 1
1	3	9000000000000001E	単位名称s3	10	10	0	0	内 セット	3 2
1	4	9000000000000001E	単位名称s4	50	50	0	0	内 セット	4 3
1	5	9000000000000001E	単位名称s1	63	63	0	0	内 セット	5 4
27	90000000000000027E	単位名称u23	55	55	0	0	内 セット	27 26	
28	90000000000000028E	単位名称u24	88	88	0	0	内 セット	28 27	
29	90000000000000029E	単位名称u25	147	147	0	0	内 セット	29 4	
30	90000000000000030E	単位名称u26	52	52	0	0	内 セット	30 29	
31	90000000000000031E	単位名称u27	55	55	0	0	内 セット	31 30	
32	90000000000000032E	単位名称u28	203	203	0	0	内 セット	32 28	
33	90000000000000033E	単位名称u29	66	66	0	0	内 セット	33 32	
34	90000000000000034E	単位名称u30	36	36	0	0	内 セット	34	

THE NUMBER OF WORKS IN COMPOSITION : TOTAL :

THE EXPECTED NUMBER OF PRODUCTS: UNITS

THE NUMBER OF DEFECTIVE PRODUCT: UNITS

THE NUMBER OF INITIAL PRODUCTS: UNITS

INVESTED INTO TOP OF ASSEMBLY LINE: MINUTES

WORKING TIME: MINUTES

BREAK: MINUTES

MORNING MEETING TIME: MINUTES

EXERCISE TIME: MINUTES

LINE STOP TIME: MINUTES

OTHERS: MINUTES

OPERABLE TIME: MINUTES

EXPECTED COMPOSITION EFFICIENCY:

CALCULATE

7710a 7710b 7710c 7710d

7720a 7720b 7720c 7720d

7730

FIG. 78

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

7801
UNIT WORK NAME :

7802
PROVISIONAL MANHOUR : (RU)

REMARKS :

FIG. 79

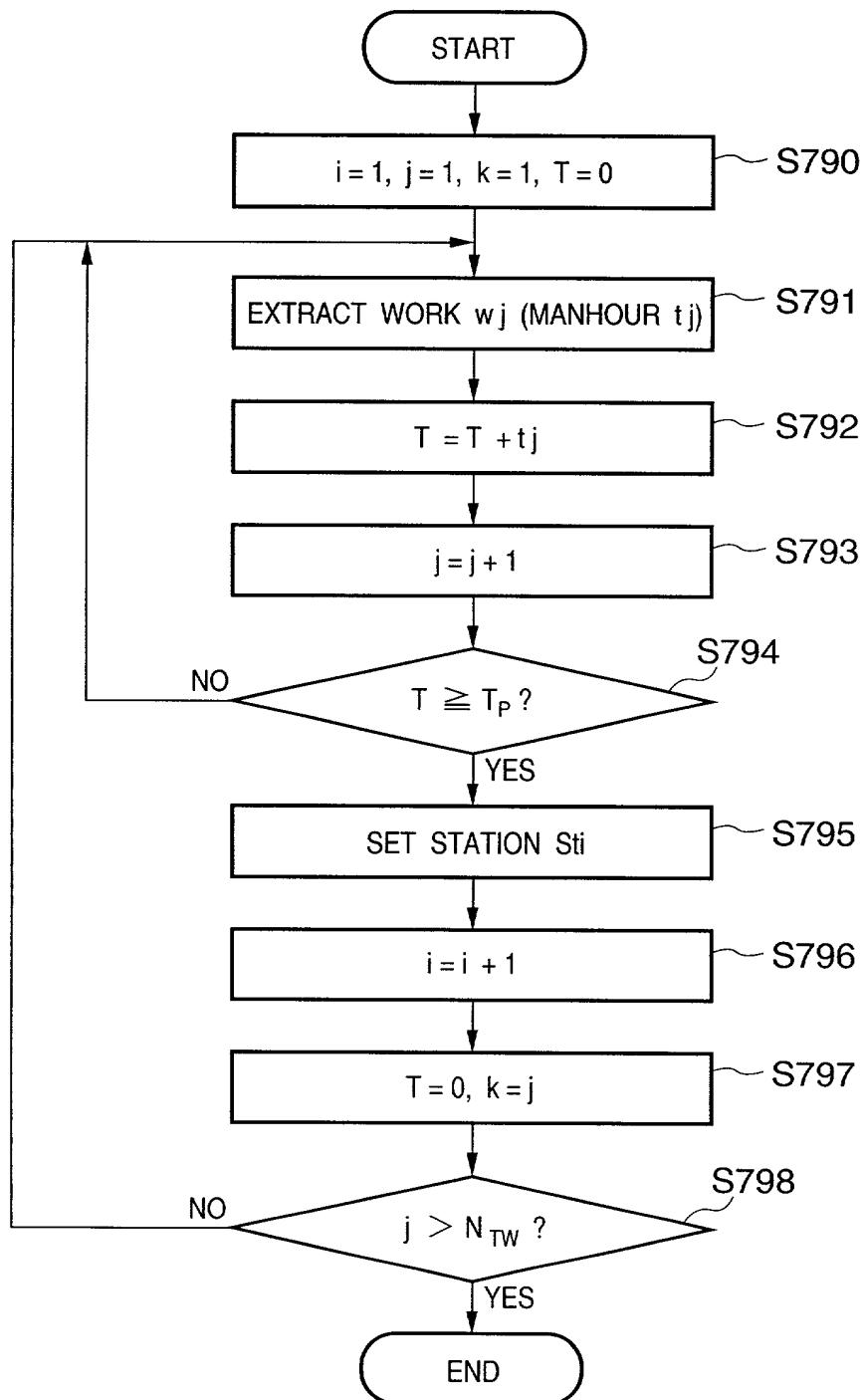
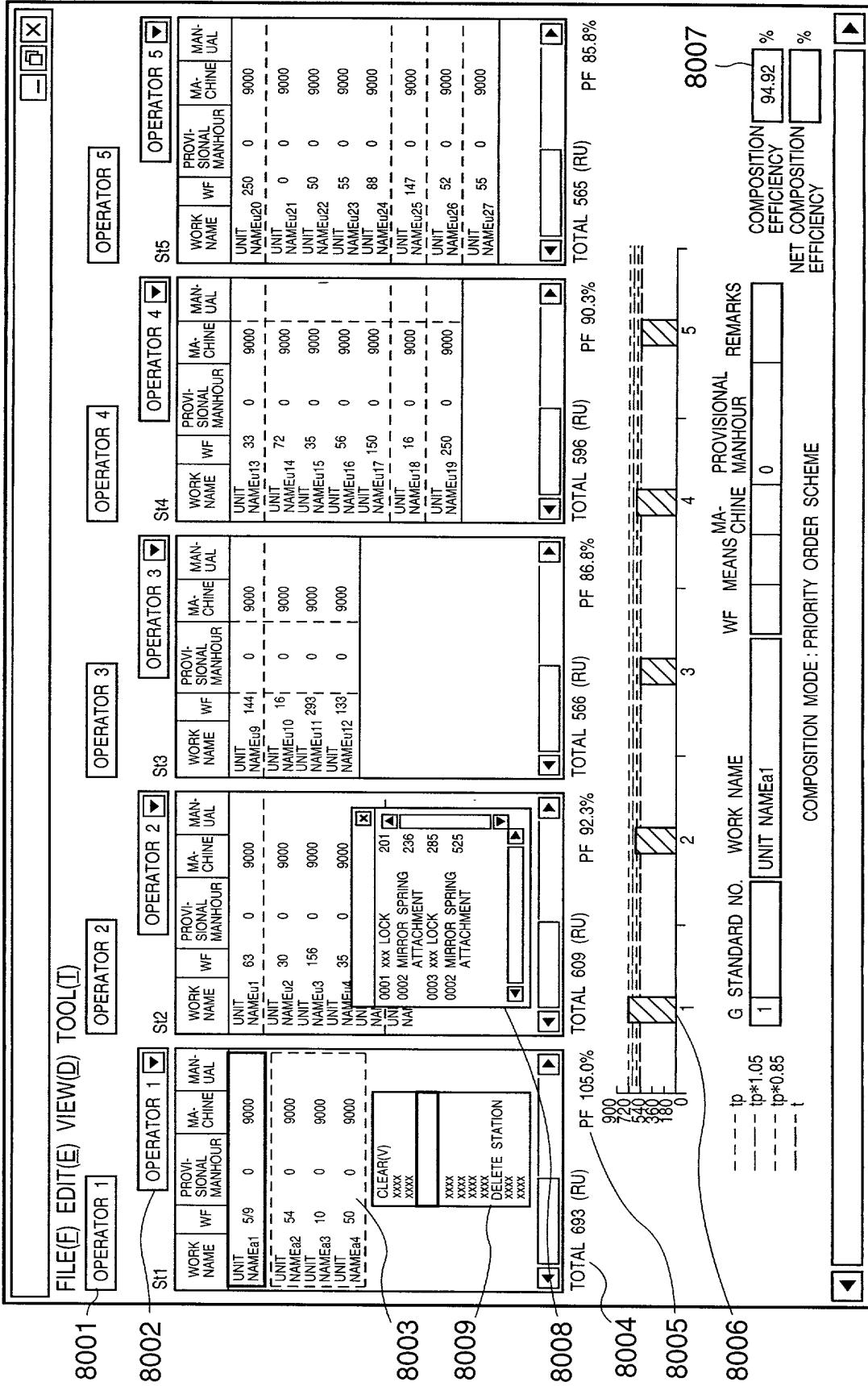


FIG. 80



F I G. 81

STATION 1

WORK NAME	MANHOUR
A1	10
A2	20
A3	12
A4	50

STATION 2

WORK NAME	MANHOUR
B1	10
B2	25
B3	11
B4	8

MANHOUR IN STATION = 92

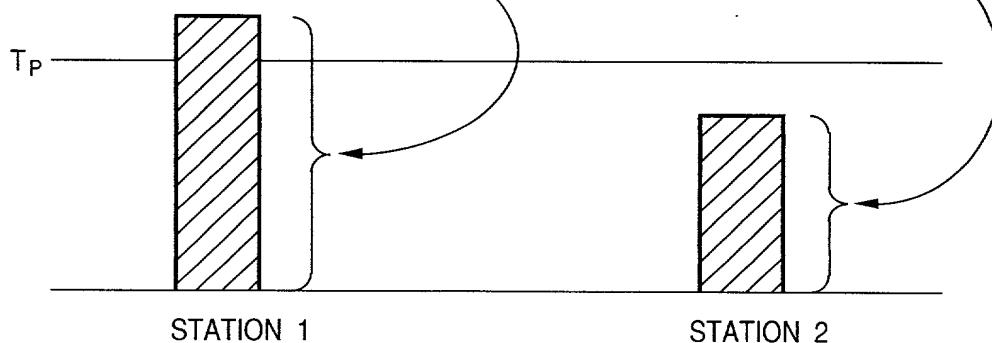


FIG. 82

STATION 1

WORK NAME	MANHOUR
A1	10
A2	20
A3	12
A4 - 1	25
A4 - 2	25

STATION 2

WORK NAME	MANHOUR
B1	10
B2	25
B3	11
B4	8

MANHOUR IN STATION = 92

MANHOUR IN STATION = 54

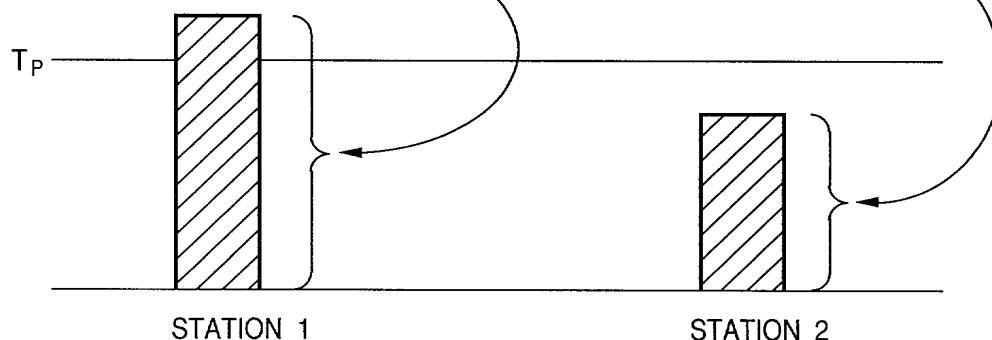


FIG. 83

STATION 1

WORK NAME	MANHOUR
A1	10
A2	20
A3	12
A4 - 1	25

MANHOUR IN STATION = 77

STATION 2

WORK NAME	MANHOUR
A4 - 2	25
B1	10
B2	25
B3	11

MANHOUR IN STATION = 79

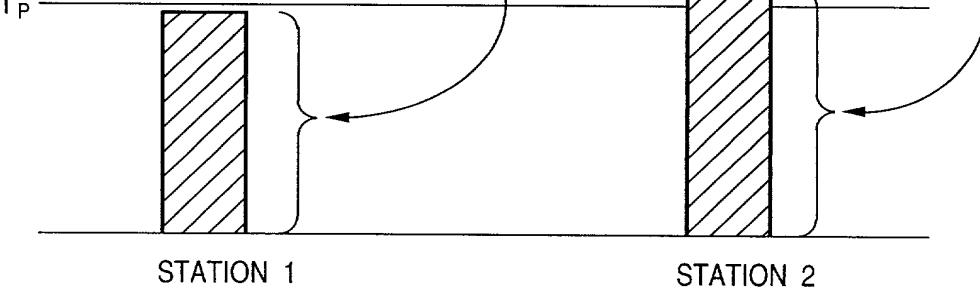
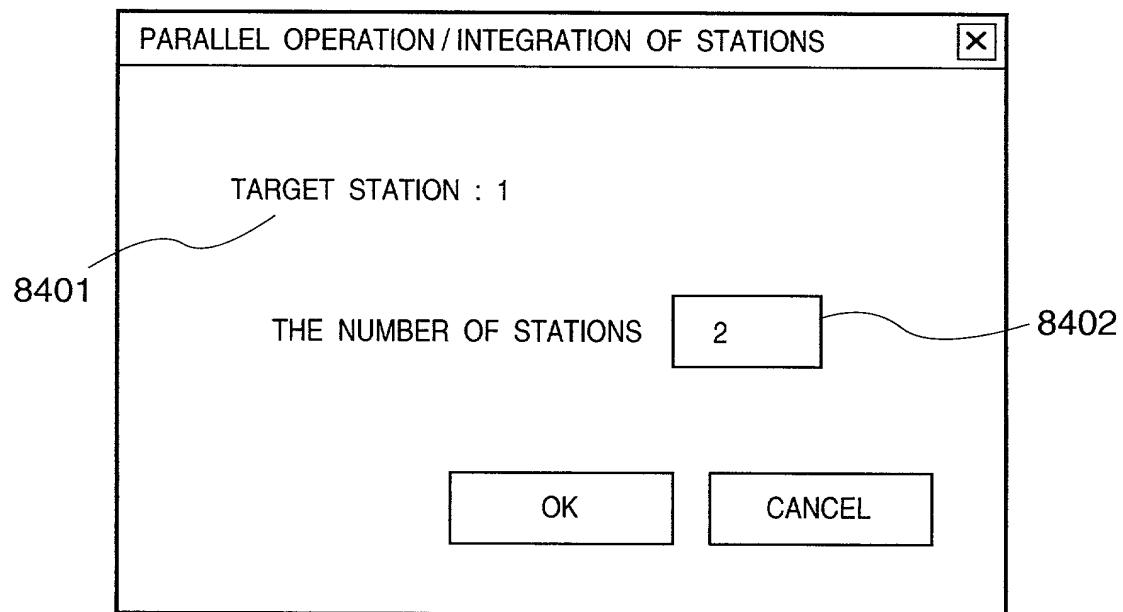
 T_p 

FIG. 84



85
FIG.

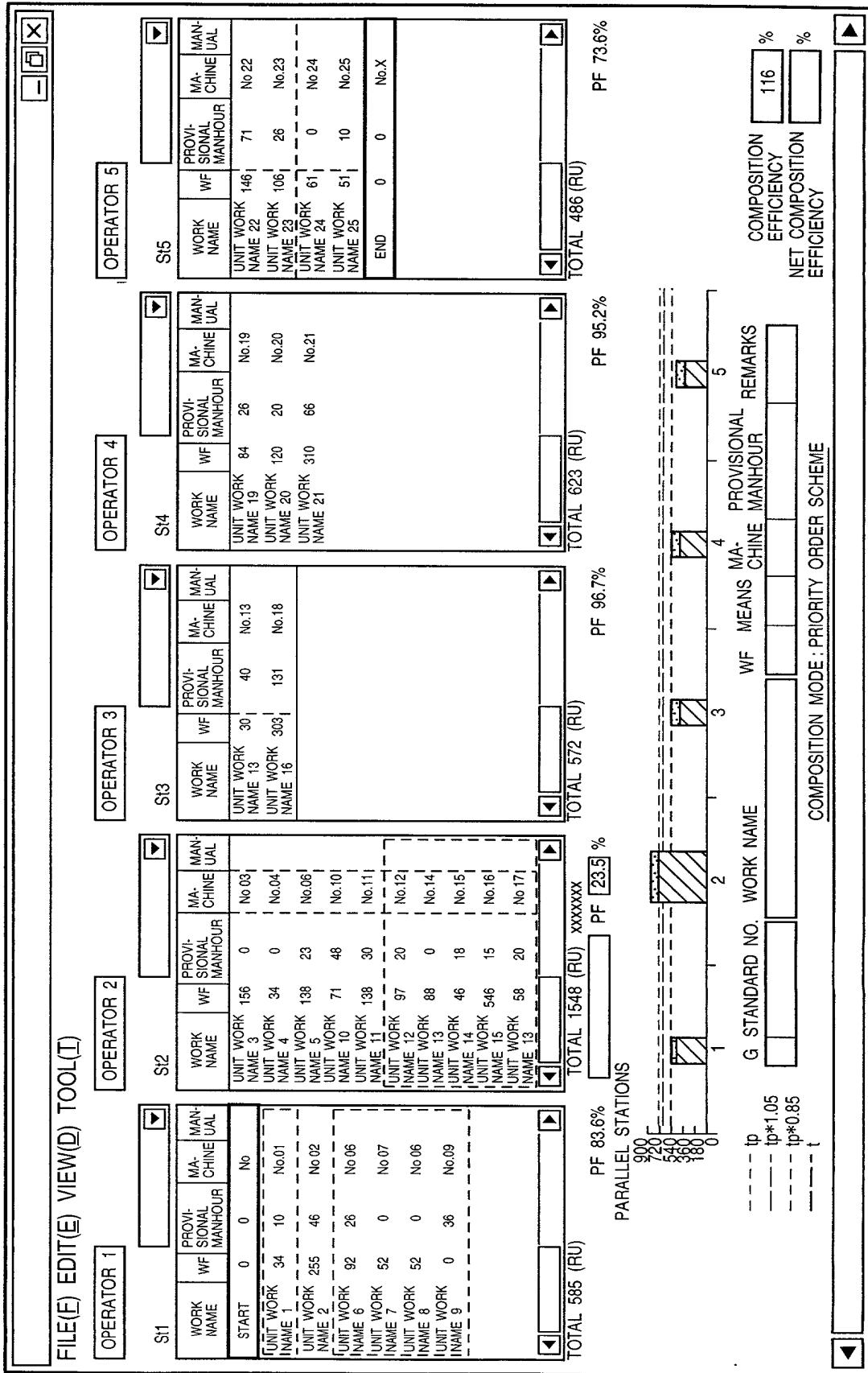


FIG. 86

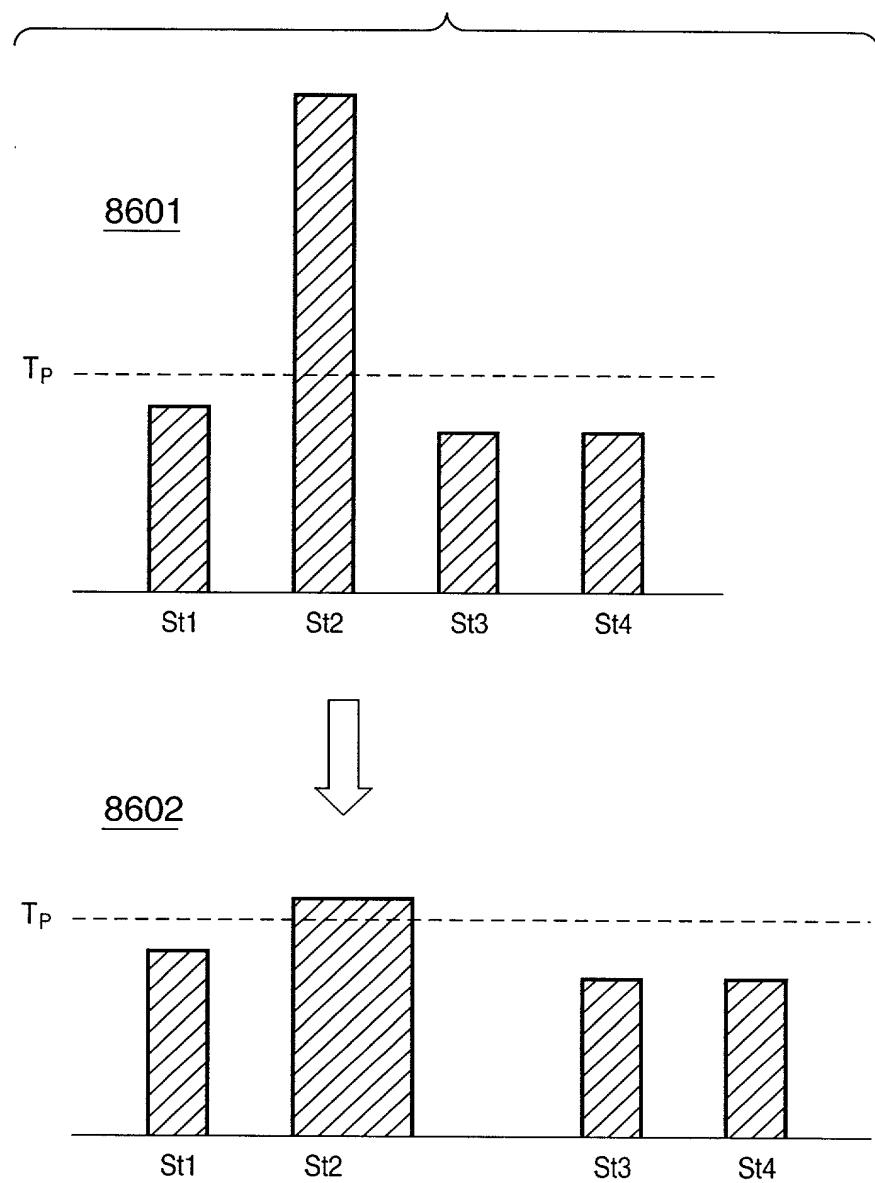


FIG. 87

USER REGISTRATION	
NAME CODE :	<input type="text" value="12345"/> 8701
NAME :	<input type="text" value="田中"/> 8702 <input type="text" value="一郎"/>
POSITION :	<input type="text" value="kumitate"/> 8703 <input type="button" value="▼"/>
PASSWORD :	<input type="text" value="12345"/> 8704
AUTHORITY :	<input type="text"/> 8705
<input type="button" value="OK"/> <input type="button" value="CANCEL"/>	

FIG. 88

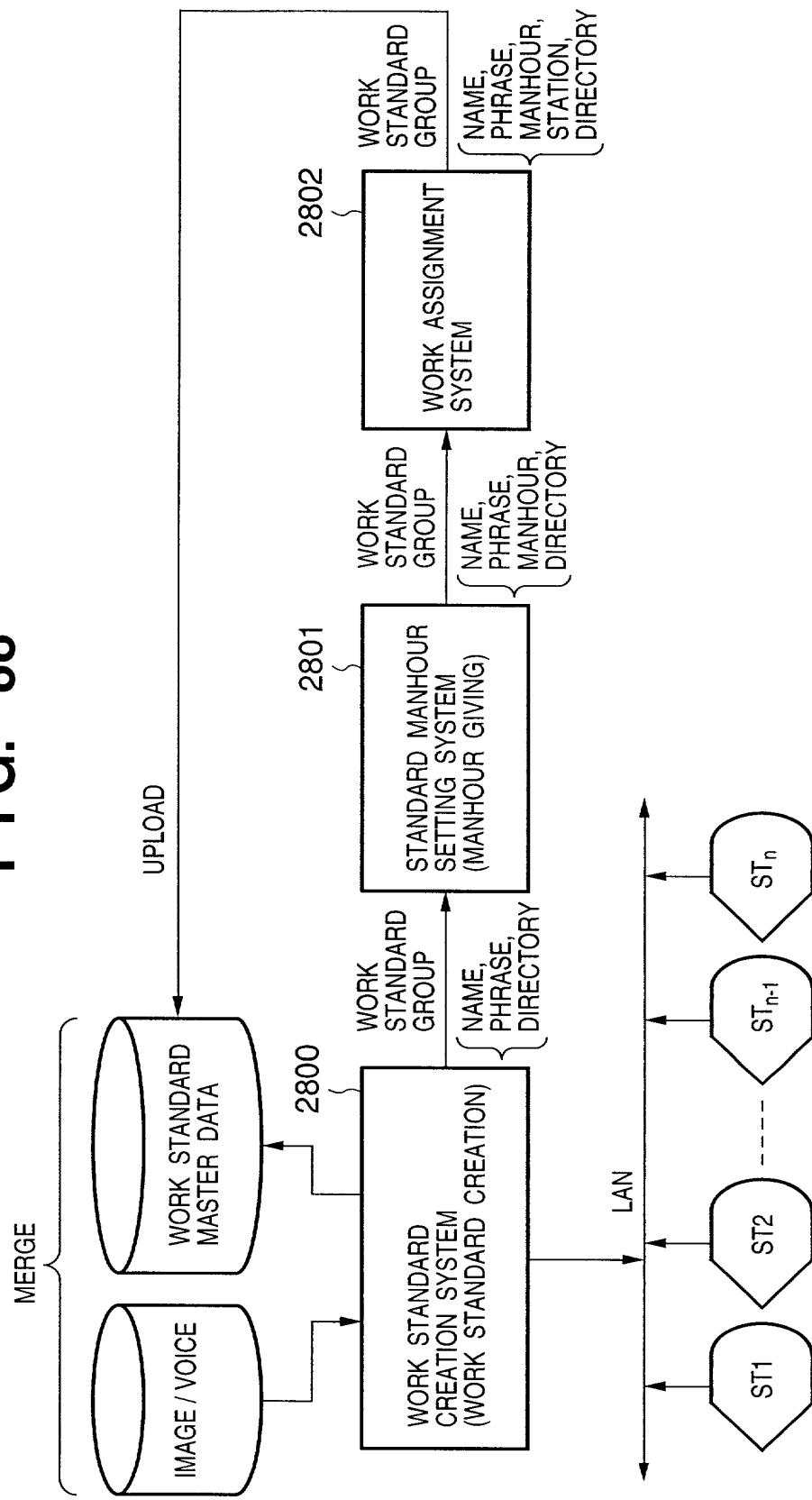
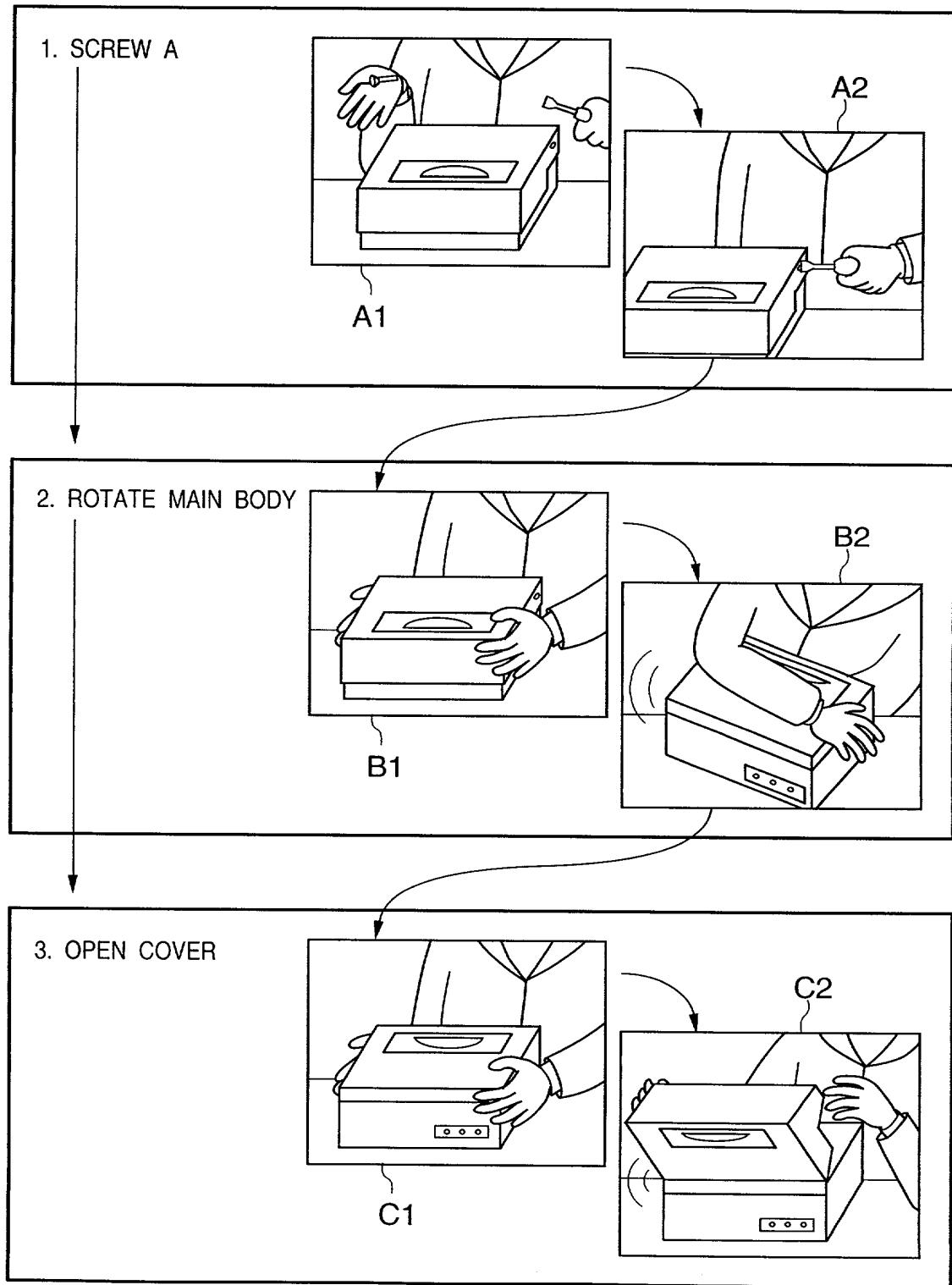


FIG. 89

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DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxxx1	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TOQUE 10Kg.M	
xxxxxx2	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TOQUE 20Kg.M	
xxxxxx3	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TOQUE 30Kg.M	
...
yyyyyy1	ROTATE	ROTATE CLOCKWISE	DISTANCE MOVEMENT 20mm		
yyyyyy2	ROTATE	ROTATE COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm		...
...
zzzzzz1	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g	
zzzzzz2	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g	
...

F I G. 90



F I G. 91

9101 9102

SETTING OF COMPONENT SYMBOL		
PRODUCT SYMBOL :	BJ - 970909	
COMPONENT SYMBOL :	CH	
COMPONENT NAME :	CHECK	
<input type="button" value="OK"/>	<input type="button" value="SEARCH COMPONENT"/>	<input type="button" value="CANCEL"/>

FIG. 92

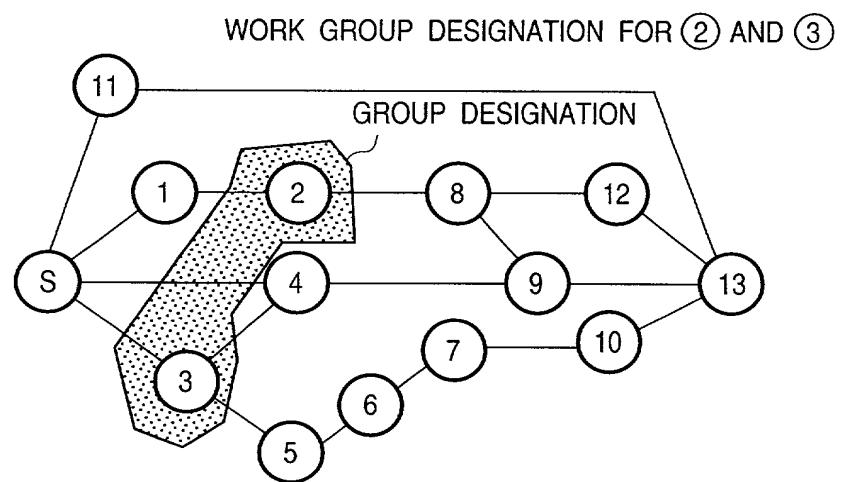


FIG. 93

WORK GROUP DESIGNATION FOR ② AND ⑧

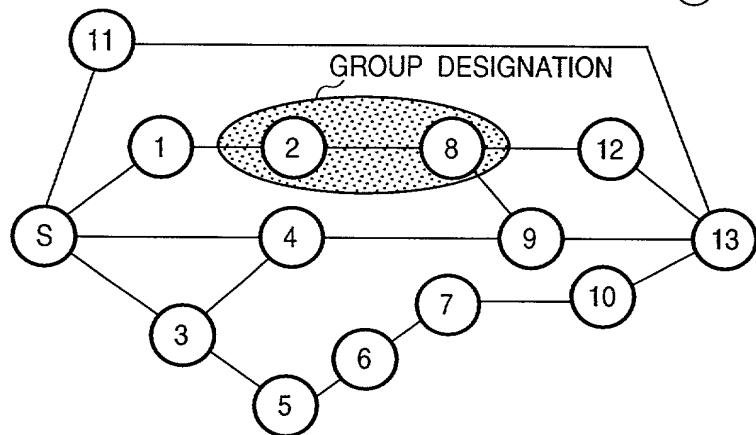


FIG. 94

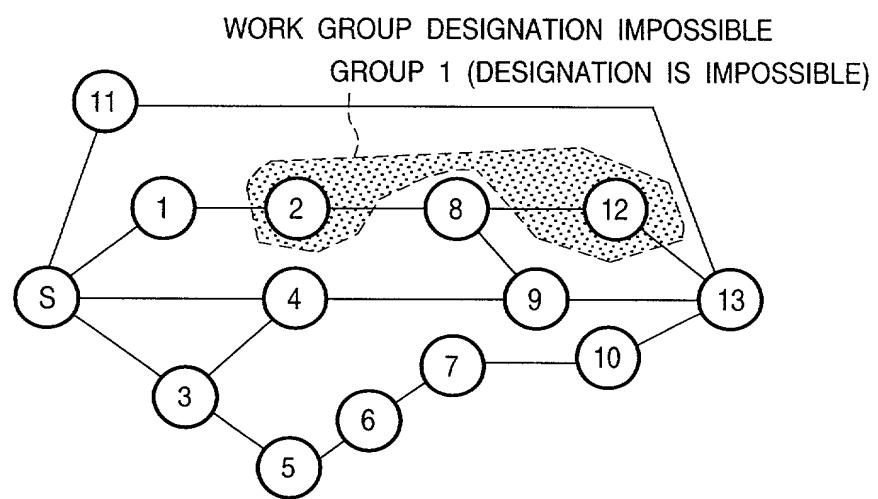
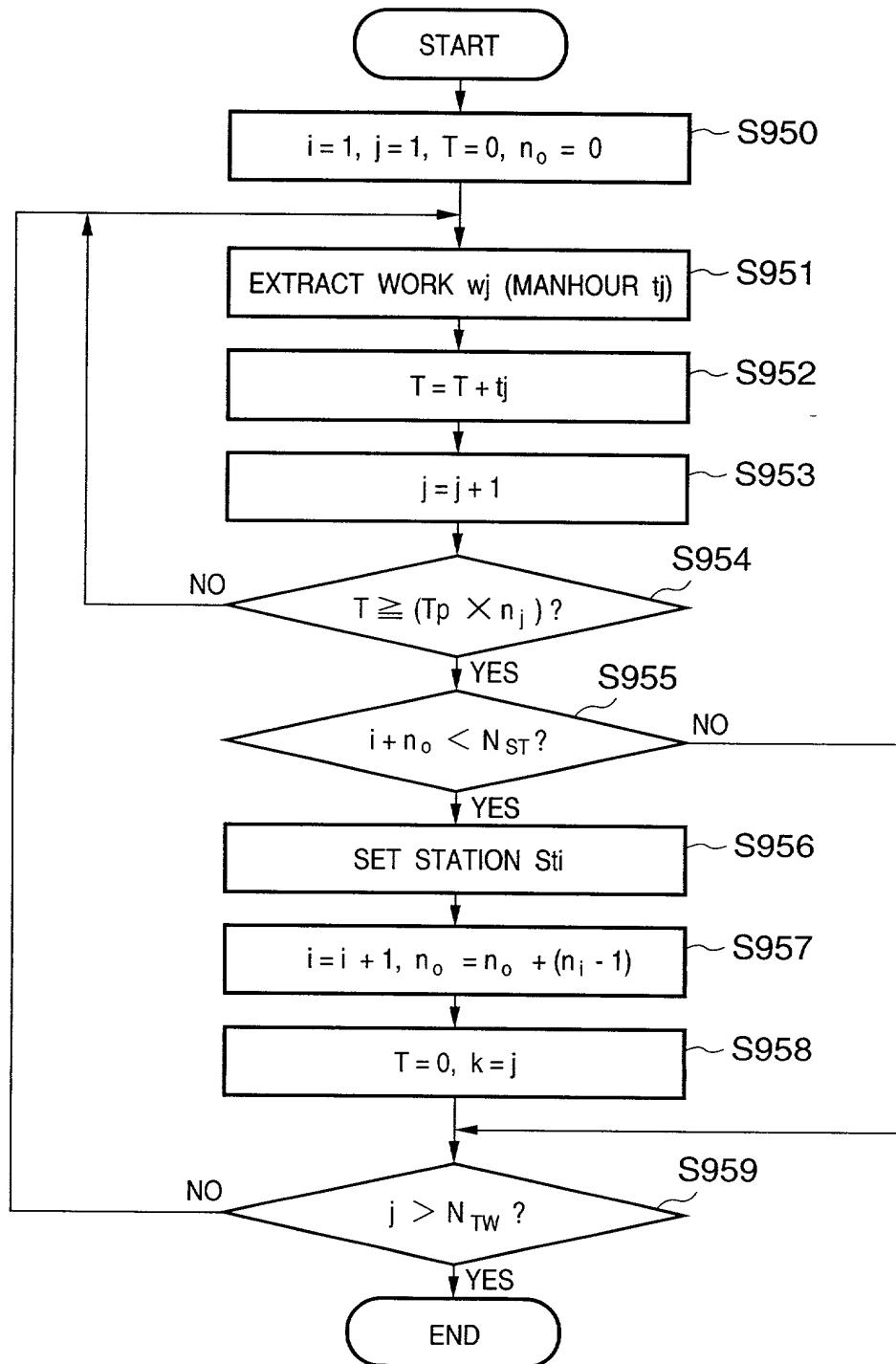


FIG. 95

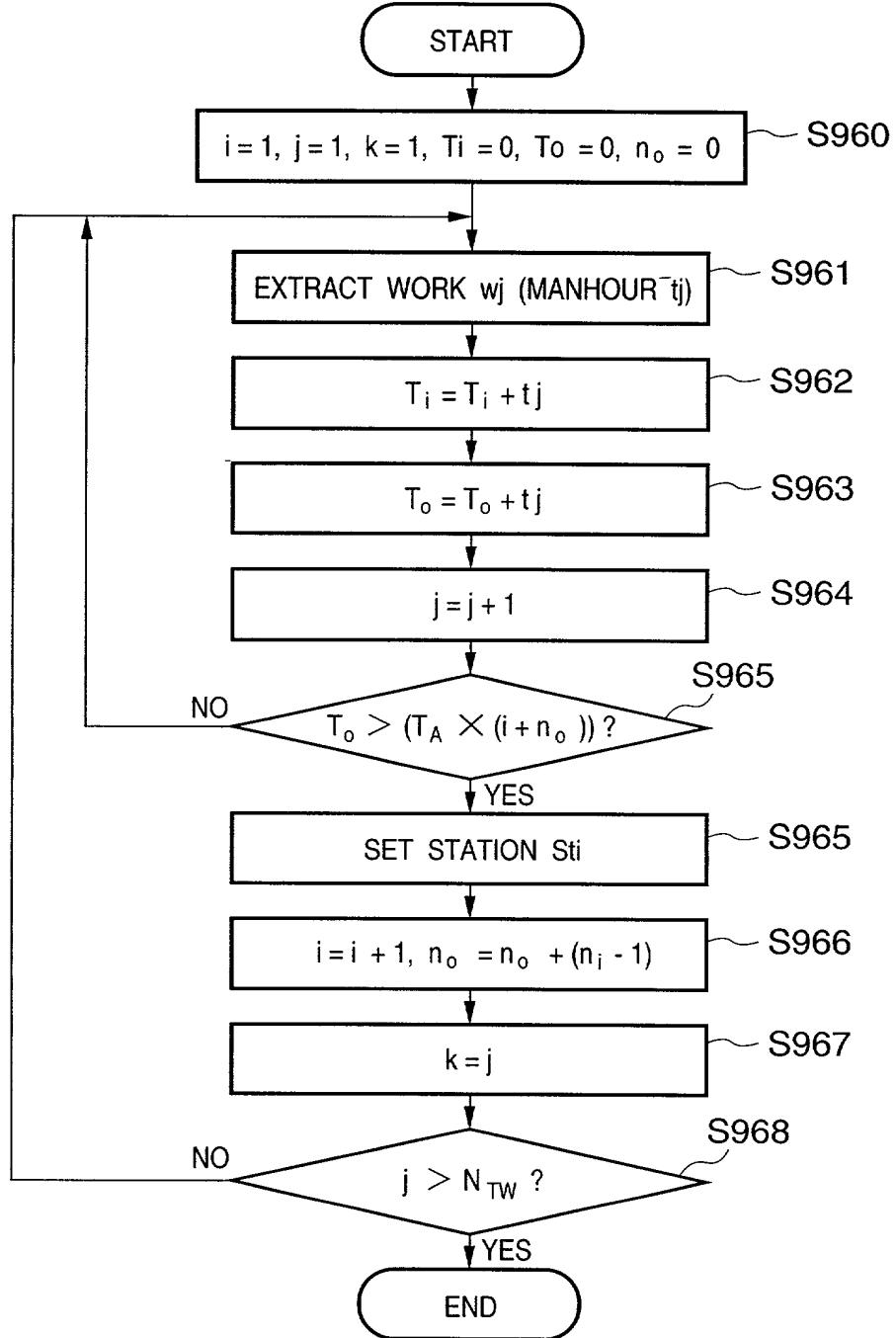


N_{ST} : THE NUMBER OF STATIONS

n_i : i STATION PARALLEL NUMBER

n_0 : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 96



N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOUR

TA : STATION MANHOUR AVERAGE VALUE

$$TA = WF / N_{ST}$$

To : TOTAL ACCUMULATED MANHOUR

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 97

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FILE(E) EDIT(E) VIEW(D) TOOL(T)		OPERATOR 1		OPERATOR 2		OPERATOR 3		OPERATOR 4		OPERATOR 5		OPERATOR 6		
S1		S12		S13		S14		S15		S16		S17		
WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	WORK NAME	WF	PROV- SIONAL MANHOUR	MA- CHINE UAL	WORK NAME	WF	
START	0	0	No.	UNIT WORK	15:6	0	No.03	UNIT WORK	30	40	No.13	UNIT WORK	84	26
NAME 1	34	10	No.01	NAME 3	0	No.04	NAME 4	UNIT WORK	34	0	No.18	NAME 13	19	No.19
NAME 2	25	46	No.02	NAME 4	23	No.06	NAME 5	UNIT WORK	13:8	23	No.21	NAME 20	120	No.20
NAME 3	92	26	No.06	NAME 5	7	No.10	NAME 6	UNIT WORK	10	48	No.24	NAME 21	310	No.21
NAME 4	6	1	No.07	NAME 6	1	No.11	NAME 7	UNIT WORK	13:8	30	No.25	NAME 22	146	No.22
NAME 5	52	0	No.08	NAME 7	20	No.12	NAME 8	UNIT WORK	9:7	20	No.23	NAME 23	106	No.23
NAME 6	52	0	No.09	NAME 8	0	No.14	NAME 9	UNIT WORK	8:8	0	No.24	NAME 24	61	No.24
NAME 7	36	0	No.10	NAME 9	18	No.15	NAME 10	UNIT WORK	4:6	18	No.25	NAME 25	51	No.25
NAME 8	0	No.11	No.11	NAME 10	15	No.16	NAME 11	UNIT WORK	5:6	15	No.26	NAME 26	0	No.26
NAME 9	0	No.12	No.12	NAME 12	20	No.17	NAME 13	UNIT WORK	5:8	20	No.27	NAME 27	71	No.27
NAME 10	0	No.13	No.13	NAME 14	15	No.18	NAME 15	UNIT WORK	5:6	15	No.28	NAME 28	26	No.28
NAME 11	0	No.14	No.14	NAME 16	0	No.19	NAME 17	UNIT WORK	5:8	20	No.29	NAME 29	0	No.29
NAME 12	0	No.15	No.15	NAME 18	15	No.20	NAME 19	UNIT WORK	5:8	20	No.30	NAME 30	120	No.30
NAME 13	0	No.16	No.16	NAME 19	15	No.21	NAME 20	UNIT WORK	5:8	20	No.31	NAME 31	66	No.31
NAME 14	0	No.17	No.17	NAME 21	0	No.22	NAME 22	UNIT WORK	5:8	20	No.32	NAME 32	106	No.32
NAME 15	0	No.18	No.18	NAME 23	0	No.23	NAME 24	UNIT WORK	5:8	20	No.33	NAME 33	61	No.33
NAME 16	0	No.19	No.19	NAME 25	0	No.24	NAME 26	UNIT WORK	5:8	20	No.34	NAME 34	0	No.34
NAME 17	0	No.20	No.20	NAME 27	0	No.25	NAME 28	UNIT WORK	5:8	20	No.35	NAME 35	10	No.35
NAME 18	0	No.21	No.21	NAME 29	0	No.26	NAME 30	UNIT WORK	5:8	20	No.36	NAME 36	0	No.36
NAME 19	0	No.22	No.22	NAME 31	0	No.27	NAME 32	UNIT WORK	5:8	20	No.37	NAME 37	0	No.37
NAME 20	0	No.23	No.23	NAME 33	0	No.28	NAME 34	UNIT WORK	5:8	20	No.38	NAME 38	0	No.38
NAME 21	0	No.24	No.24	NAME 35	0	No.29	NAME 36	UNIT WORK	5:8	20	No.39	NAME 39	0	No.39
NAME 22	0	No.25	No.25	NAME 37	0	No.30	NAME 38	UNIT WORK	5:8	20	No.40	NAME 40	0	No.40
NAME 23	0	No.26	No.26	NAME 39	0	No.31	NAME 40	UNIT WORK	5:8	20	No.41	NAME 41	0	No.41
NAME 24	0	No.27	No.27	NAME 41	0	No.32	NAME 42	UNIT WORK	5:8	20	No.42	NAME 42	0	No.42
NAME 25	0	No.28	No.28	NAME 43	0	No.33	NAME 44	UNIT WORK	5:8	20	No.43	NAME 43	0	No.43
NAME 26	0	No.29	No.29	NAME 44	0	No.34	NAME 45	UNIT WORK	5:8	20	No.44	NAME 44	0	No.44
NAME 27	0	No.30	No.30	NAME 45	0	No.35	NAME 46	UNIT WORK	5:8	20	No.45	NAME 45	0	No.45
NAME 28	0	No.31	No.31	NAME 46	0	No.36	NAME 47	UNIT WORK	5:8	20	No.46	NAME 46	0	No.46
NAME 29	0	No.32	No.32	NAME 47	0	No.37	NAME 48	UNIT WORK	5:8	20	No.47	NAME 47	0	No.47
NAME 30	0	No.33	No.33	NAME 48	0	No.38	NAME 49	UNIT WORK	5:8	20	No.48	NAME 48	0	No.48
NAME 31	0	No.34	No.34	NAME 49	0	No.39	NAME 50	UNIT WORK	5:8	20	No.49	NAME 49	0	No.49
NAME 32	0	No.35	No.35	NAME 50	0	No.40	NAME 51	UNIT WORK	5:8	20	No.50	NAME 50	0	No.50
NAME 33	0	No.36	No.36	NAME 51	0	No.41	NAME 52	UNIT WORK	5:8	20	No.51	NAME 51	0	No.51
NAME 34	0	No.37	No.37	NAME 52	0	No.42	NAME 53	UNIT WORK	5:8	20	No.52	NAME 52	0	No.52
NAME 35	0	No.38	No.38	NAME 53	0	No.43	NAME 54	UNIT WORK	5:8	20	No.53	NAME 53	0	No.53
NAME 36	0	No.39	No.39	NAME 54	0	No.44	NAME 55	UNIT WORK	5:8	20	No.54	NAME 54	0	No.54
NAME 37	0	No.40	No.40	NAME 55	0	No.45	NAME 56	UNIT WORK	5:8	20	No.55	NAME 55	0	No.55
NAME 38	0	No.41	No.41	NAME 56	0	No.46	NAME 57	UNIT WORK	5:8	20	No.56	NAME 56	0	No.56
NAME 39	0	No.42	No.42	NAME 57	0	No.47	NAME 58	UNIT WORK	5:8	20	No.57	NAME 57	0	No.57
NAME 40	0	No.43	No.43	NAME 58	0	No.48	NAME 59	UNIT WORK	5:8	20	No.58	NAME 58	0	No.58
NAME 41	0	No.44	No.44	NAME 59	0	No.49	NAME 60	UNIT WORK	5:8	20	No.59	NAME 59	0	No.59
NAME 42	0	No.45	No.45	NAME 60	0	No.50	NAME 61	UNIT WORK	5:8	20	No.60	NAME 60	0	No.60
NAME 43	0	No.46	No.46	NAME 61	0	No.51	NAME 62	UNIT WORK	5:8	20	No.61	NAME 61	0	No.61
NAME 44	0	No.47	No.47	NAME 62	0	No.52	NAME 63	UNIT WORK	5:8	20	No.62	NAME 62	0	No.62
NAME 45	0	No.48	No.48	NAME 63	0	No.53	NAME 64	UNIT WORK	5:8	20	No.63	NAME 63	0	No.63
NAME 46	0	No.49	No.49	NAME 64	0	No.54	NAME 65	UNIT WORK	5:8	20	No.64	NAME 64	0	No.64
NAME 47	0	No.50	No.50	NAME 65	0	No.55	NAME 66	UNIT WORK	5:8	20	No.65	NAME 65	0	No.65
NAME 48	0	No.51	No.51	NAME 66	0	No.56	NAME 67	UNIT WORK	5:8	20	No.66	NAME 66	0	No.66
NAME 49	0	No.52	No.52	NAME 67	0	No.57	NAME 68	UNIT WORK	5:8	20	No.67	NAME 67	0	No.67
NAME 50	0	No.53	No.53	NAME 68	0	No.58	NAME 69	UNIT WORK	5:8	20	No.68	NAME 68	0	No.68
NAME 51	0	No.54	No.54	NAME 69	0	No.59	NAME 70	UNIT WORK	5:8	20	No.69	NAME 69	0	No.69
NAME 52	0	No.55	No.55	NAME 70	0	No.60	NAME 71	UNIT WORK	5:8	20	No.70	NAME 70	0	No.70
NAME 53	0	No.56	No.56	NAME 71	0	No.61	NAME 72	UNIT WORK	5:8	20	No.71	NAME 71	0	No.71
NAME 54	0	No.57	No.57	NAME 72	0	No.62	NAME 73	UNIT WORK	5:8	20	No.72	NAME 72	0	No.72
NAME 55	0	No.58	No.58	NAME 73	0	No.63	NAME 74	UNIT WORK	5:8	20	No.73	NAME 73	0	No.73
NAME 56	0	No.59	No.59	NAME 74	0	No.64	NAME 75	UNIT WORK	5:8	20	No.74	NAME 74	0	No.74
NAME 57	0	No.60	No.60	NAME 75	0	No.65	NAME 76	UNIT WORK	5:8	20	No.75	NAME 75	0	No.75
NAME 58	0	No.61	No.61	NAME 76	0	No.66	NAME 77	UNIT WORK	5:8	20	No.76	NAME 76	0	No.76
NAME 59	0	No.62	No.62	NAME 77	0	No.67	NAME 78	UNIT WORK	5:8	20	No.77	NAME 77	0	No.77
NAME 60	0	No.63	No.63	NAME 78	0	No.68	NAME 79	UNIT WORK	5:8	20	No.78	NAME 78	0	No.78
NAME 61	0	No.64	No.64	NAME 79	0	No.69	NAME 80	UNIT WORK	5:8	20	No.79	NAME 79	0	No.79
NAME 62	0	No.65	No.65	NAME 80	0	No.70	NAME 81	UNIT WORK	5:8	20	No.80	NAME 80	0	No.80
NAME 63	0	No.66	No.66	NAME 81	0	No.71	NAME 82	UNIT WORK	5:8	20	No.81	NAME 81	0	No.81
NAME 64	0	No.67	No.67	NAME 82	0	No.72	NAME 83	UNIT WORK	5:8	20	No.82	NAME 82	0	No.82
NAME 65	0	No.68	No.68	NAME 83	0	No.73	NAME 84	UNIT WORK	5:8	20	No.83	NAME 83	0	No.83
NAME 66	0	No.69	No.69	NAME 84	0	No.74	NAME 85	UNIT WORK	5:8	20	No.84	NAME 84	0	No.84
NAME 67	0	No.70	No.70	NAME 85	0	No.75	NAME 86	UNIT WORK	5:8	20	No.85	NAME 85	0	No.85
NAME 68	0	No.71	No.71	NAME 86	0	No.76	NAME 87	UNIT WORK	5:8	20	No.86	NAME 86	0	No.86
NAME 69	0	No.72	No.72	NAME 87	0	No.77	NAME 88	UNIT WORK	5:8	20	No.87	NAME 87	0	No.87
NAME 70	0	No.73	No.73	NAME 88	0	No.78	NAME 89	UNIT WORK	5:8	20	No.88	NAME 88	0	No.88
NAME 71	0	No.74	No.74	NAME 89	0	No.79	NAME 90	UNIT WORK	5:8	20	No.89	NAME 89	0	No.89
NAME 72	0	No.75	No.75	NAME 90	0	No.80	NAME 91	UNIT WORK	5:8	20	No.90	NAME 90	0	No.90
NAME 73	0	No.76	No.76	NAME 91	0	No.81	NAME 92	UNIT WORK	5:8	20	No.91	NAME 91	0	No.91
NAME 74	0	No.77	No.77	NAME 92	0	No.82	NAME 93	UNIT WORK	5:8	20	No.92	NAME 92	0	No.92
NAME 75	0	No.78	No.78	NAME 93	0	No.83	NAME 94	UNIT WORK	5:8	20	No.93	NAME 93	0	No.93
NAME 76	0	No.79	No.79	NAME 94	0	No.84	NAME 95	UNIT WORK	5:8	20	No.94	NAME 94	0	No.94
NAME 77	0	No.80	No.80	NAME 95	0	No.85	NAME 96	UNIT WORK	5:8	20	No.95	NAME 95	0	No.95
NAME 78	0	No.81	No.81	NAME 96	0	No.86	NAME 97	UNIT WORK	5:8	20	No.96	NAME 96	0	No.96
NAME 79	0	No.82	No.82	NAME 97	0	No.87	NAME 98	UNIT WORK	5:8	20	No.97	NAME 97	0	No.97
NAME 80	0	No.83	No.83	NAME 98	0	No.88	NAME 99	UNIT WORK	5:8	20	No.98	NAME 98	0	No.98
NAME 81	0	No.84	No.84	NAME 99	0	No.89	NAME 100	UNIT WORK	5:8	20	No.99	NAME 99	0	No.99
NAME 82	0	No.85	No.85	NAME 100	0	No.90	NAME 101	UNIT WORK	5:8	20	No.100	NAME 100	0	No.100
NAME 83	0	No.86	No.86	NAME 101	0	No.91	NAME 102	UNIT WORK	5:8	20	No.101	NAME 101	0	No.101
NAME 84	0	No.87	No.87	NAME 102	0	No.92	NAME 103	UNIT WORK	5:8	20	No.102	NAME 102	0	No.102
NAME 85	0	No.88	No.88	NAME 103	0	No.93	NAME 104	UNIT WORK	5:8	20	No.103	NAME 103	0	No.103
NAME 86	0	No.89	No.89	NAME 104	0	No.94	NAME 105	UNIT WORK	5:8	20	No.104	NAME 104	0	No.104
NAME 87	0	No.90	No.90	NAME 105	0	No.95	NAME 106	UNIT WORK	5:8	20	No.105	NAME 105	0	No.105
NAME 88	0	No.91	No.91	NAME 106	0	No.96	NAME 107	UNIT WORK	5:8	20	No.106	NAME 106	0	No.106
NAME 89	0	No.92	No.92	NAME 107	0	No.97	NAME 108	UNIT WORK	5:8	20	No.107	NAME 107	0	No.107
NAME 90	0	No.93	No.93	NAME 108	0	No.98	NAME 109	UNIT WORK	5:8	20	No.108	NAME 108	0	No.108
NAME 91	0	No.94	No.94	NAME 109	0	No.99	NAME 110	UNIT WORK	5:8	20	No.109	NAME 109	0	No.109
NAME 92	0	No.95	No.95	NAME 110	0	No.100	NAME 111	UNIT WORK	5:8	20	No.110	NAME 110	0	No.110
NAME 93	0	No.96	No.96	NAME 111	0	No.101	NAME 112	UNIT WORK	5:8	20	No.111	NAME 111	0	No.111
NAME 94	0	No.97	No.97	NAME 112	0	No.102	NAME 113	UNIT WORK	5:8	20	No.112	NAME 112	0	No.112
NAME 95	0	No.98	No.98	NAME 113	0	No.103	NAME 114	UNIT WORK	5:8	20	No.113	NAME 113	0	No.113
NAME 96	0	No.99	No.99	NAME 114	0	No.104	NAME 115	UNIT WORK	5:8	20	No.114	NAME 114	0	No.114
NAME 97	0	No.100	No.100	NAME 115	0	No.105	NAME 116	UNIT WORK	5:8	20	No.115	NAME 115	0	No.115
NAME 98	0	No.101	No.101	NAME 116	0	No.106	NAME 117	UNIT WORK	5:8					